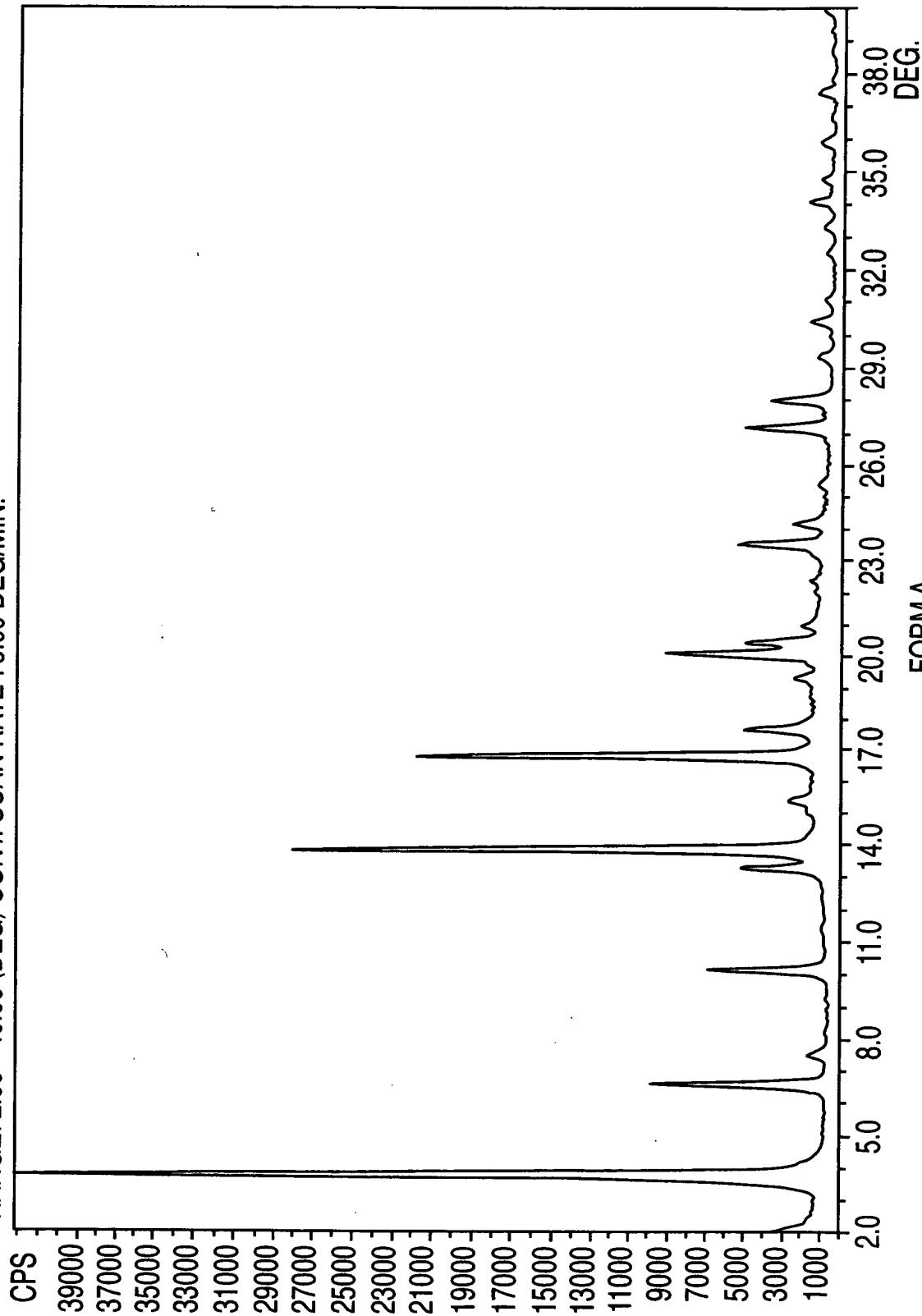




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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM A
FIG. 1

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

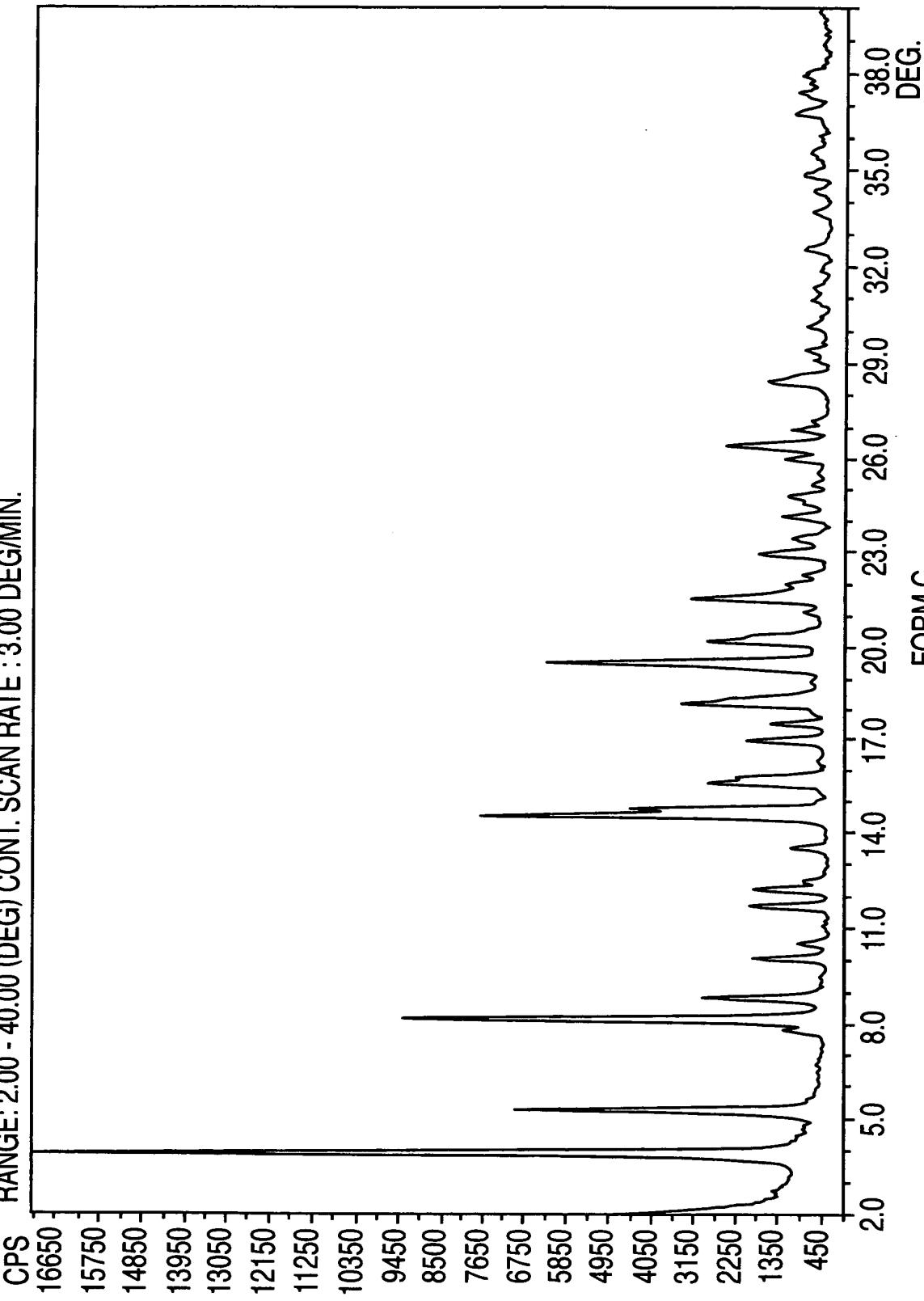


FIG. 2
FORM C

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN. TEVA

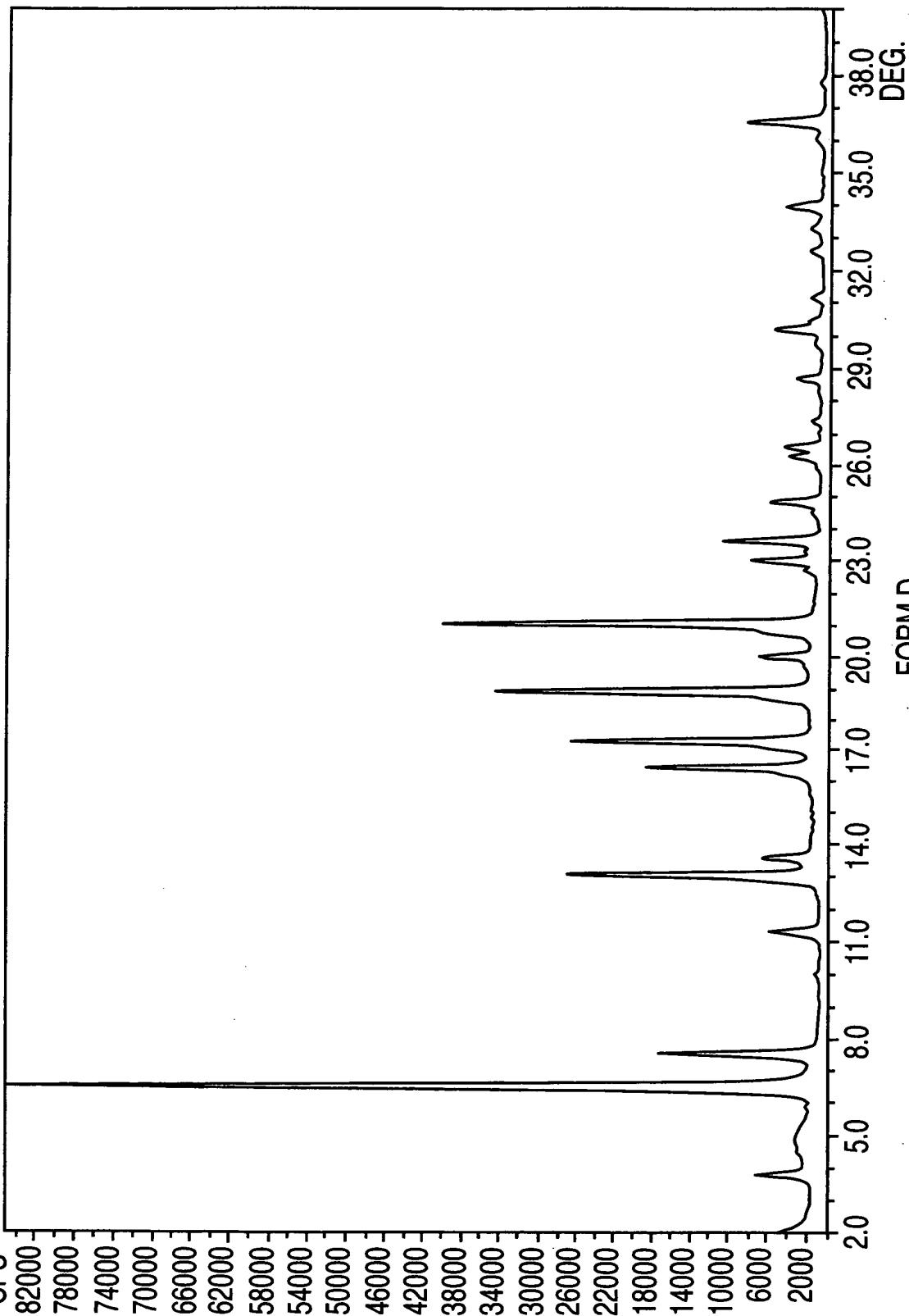
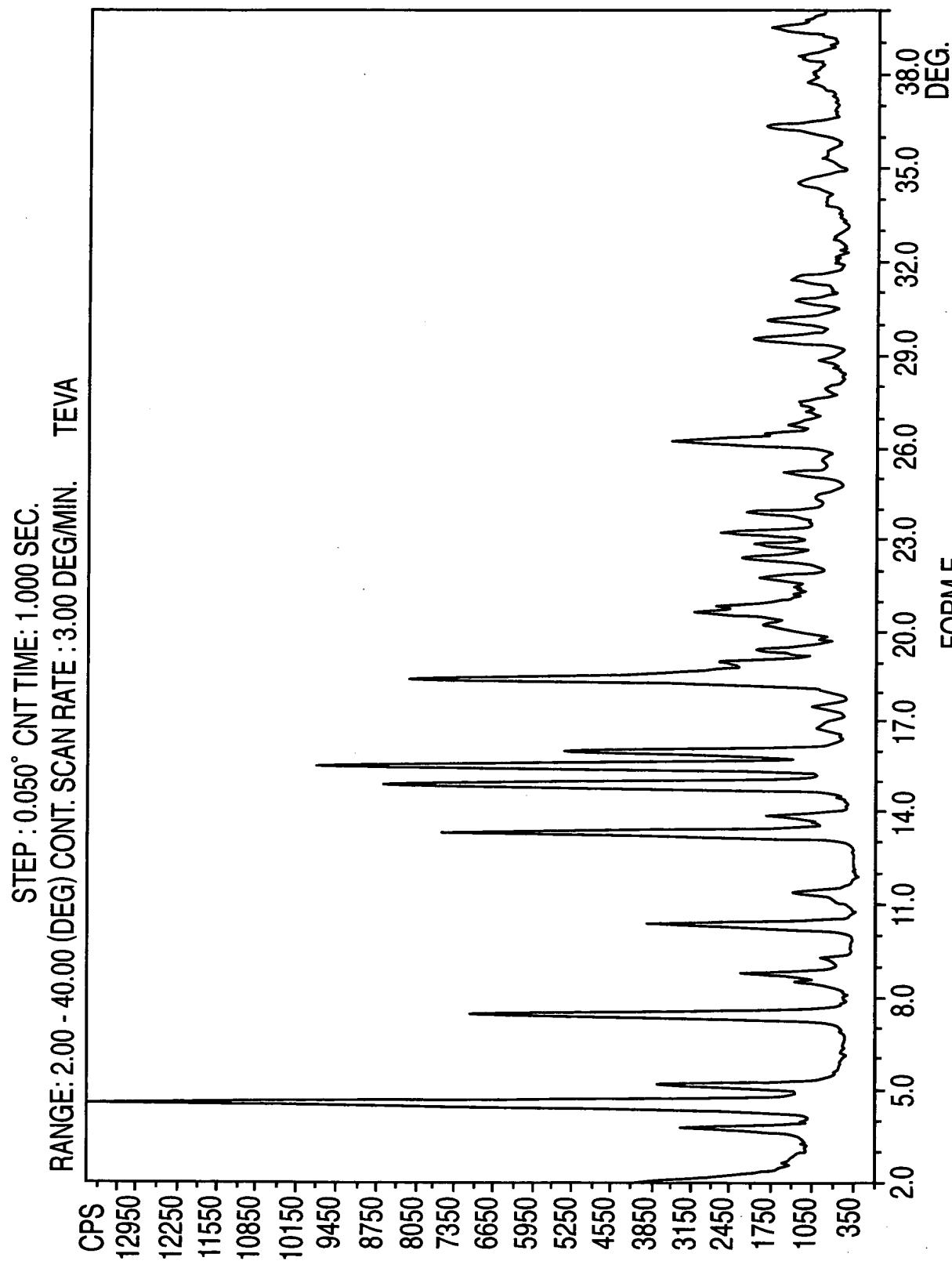
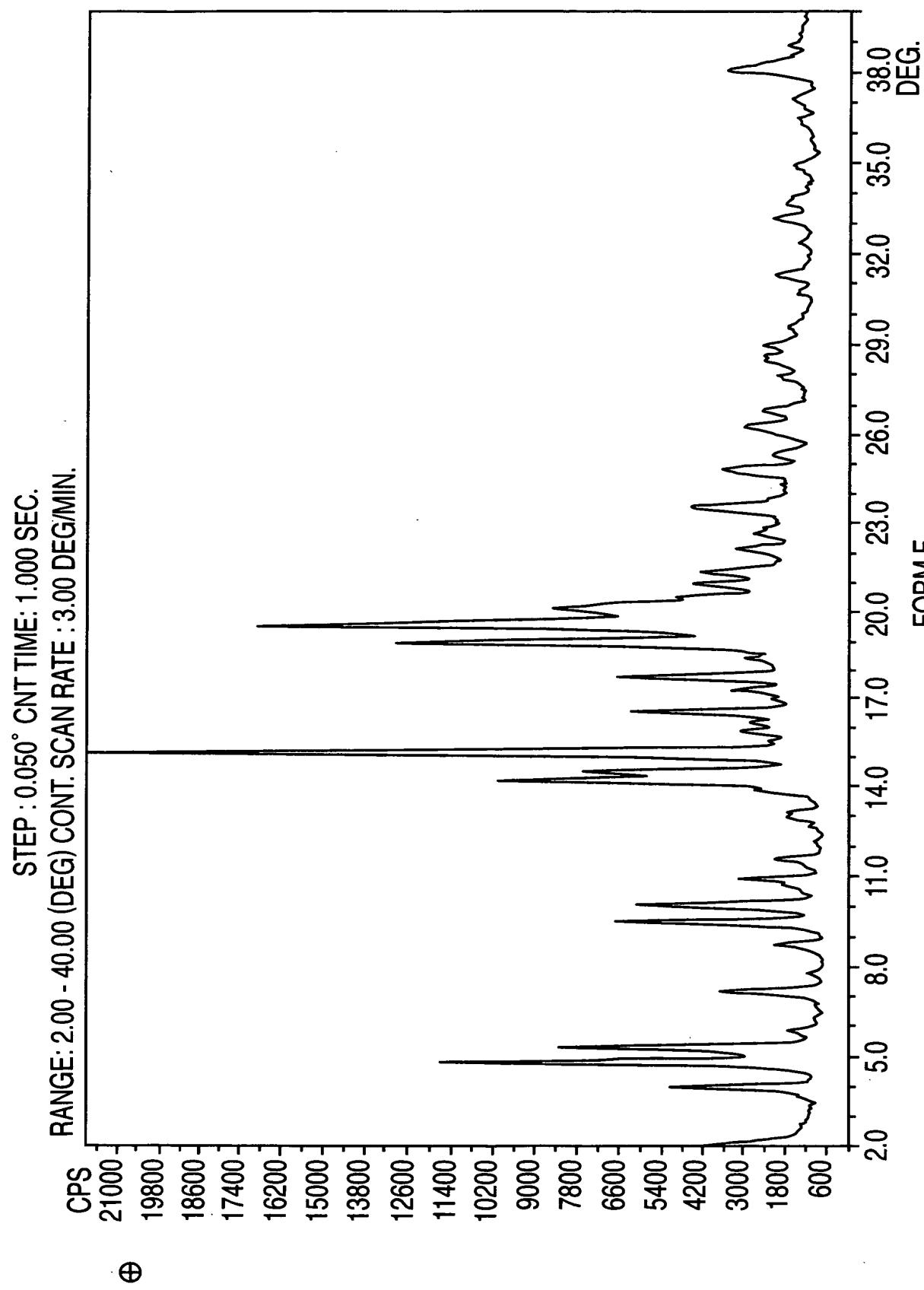
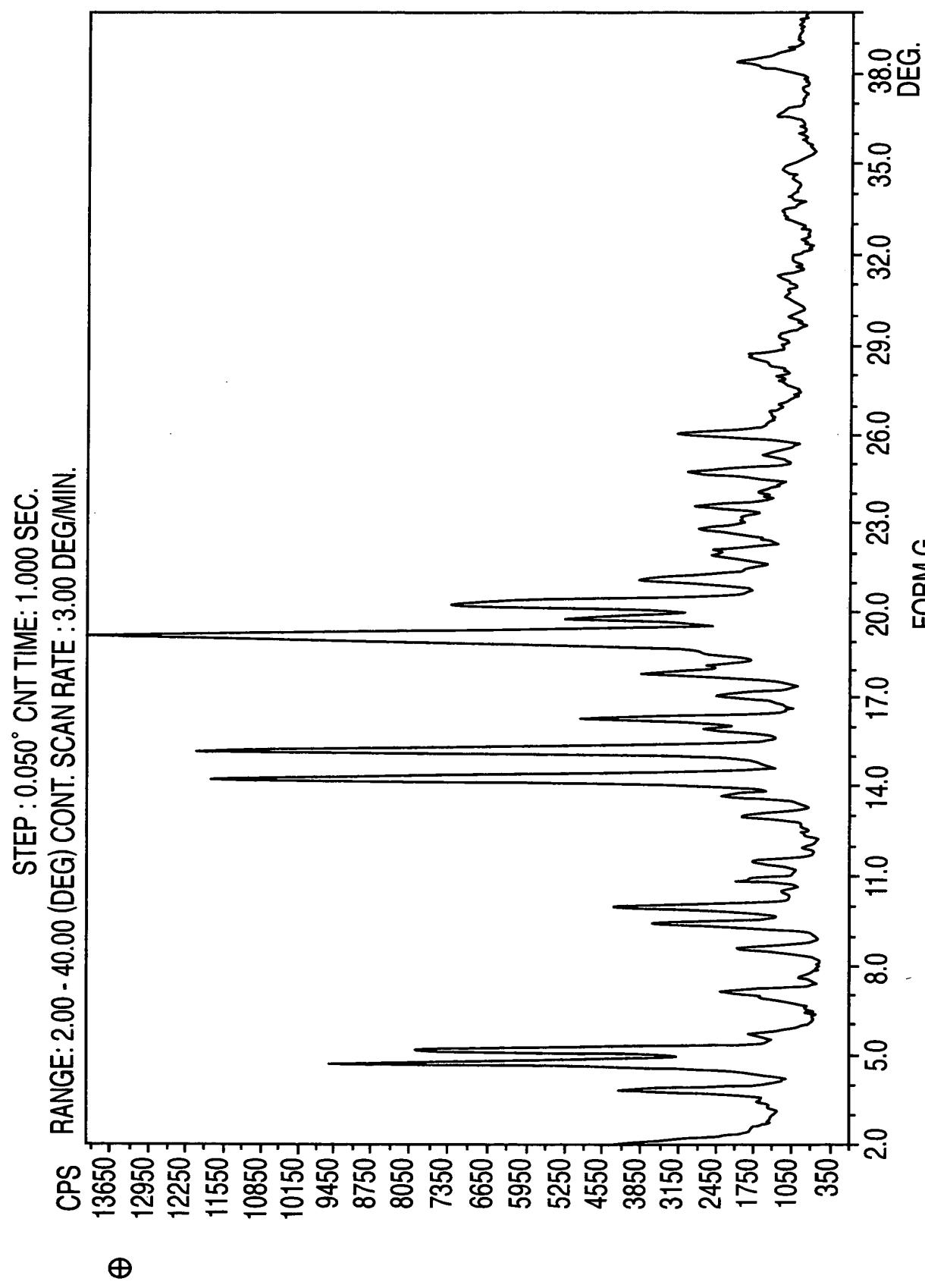


FIG. 3

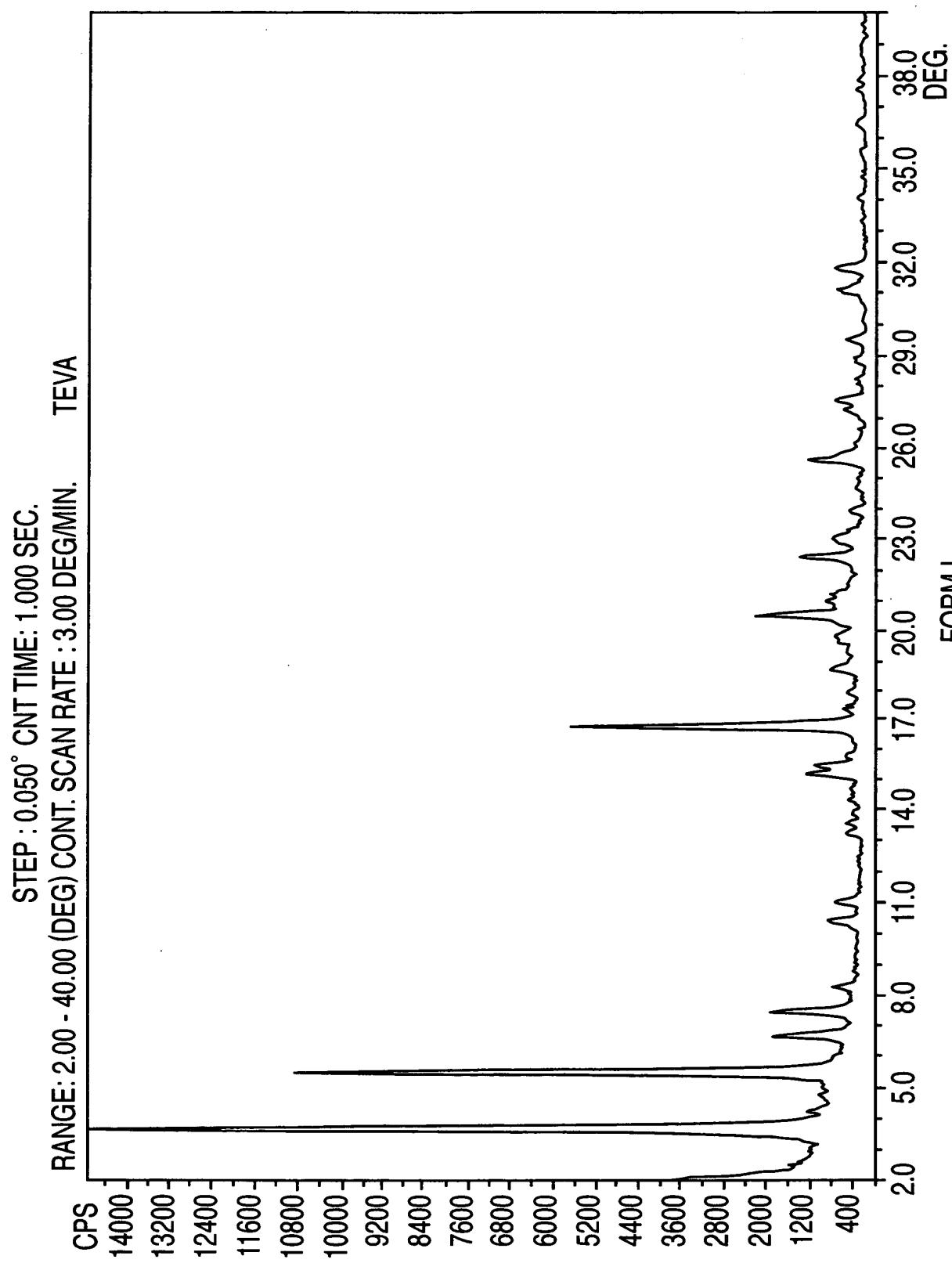


FORM E
FIG. 4





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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

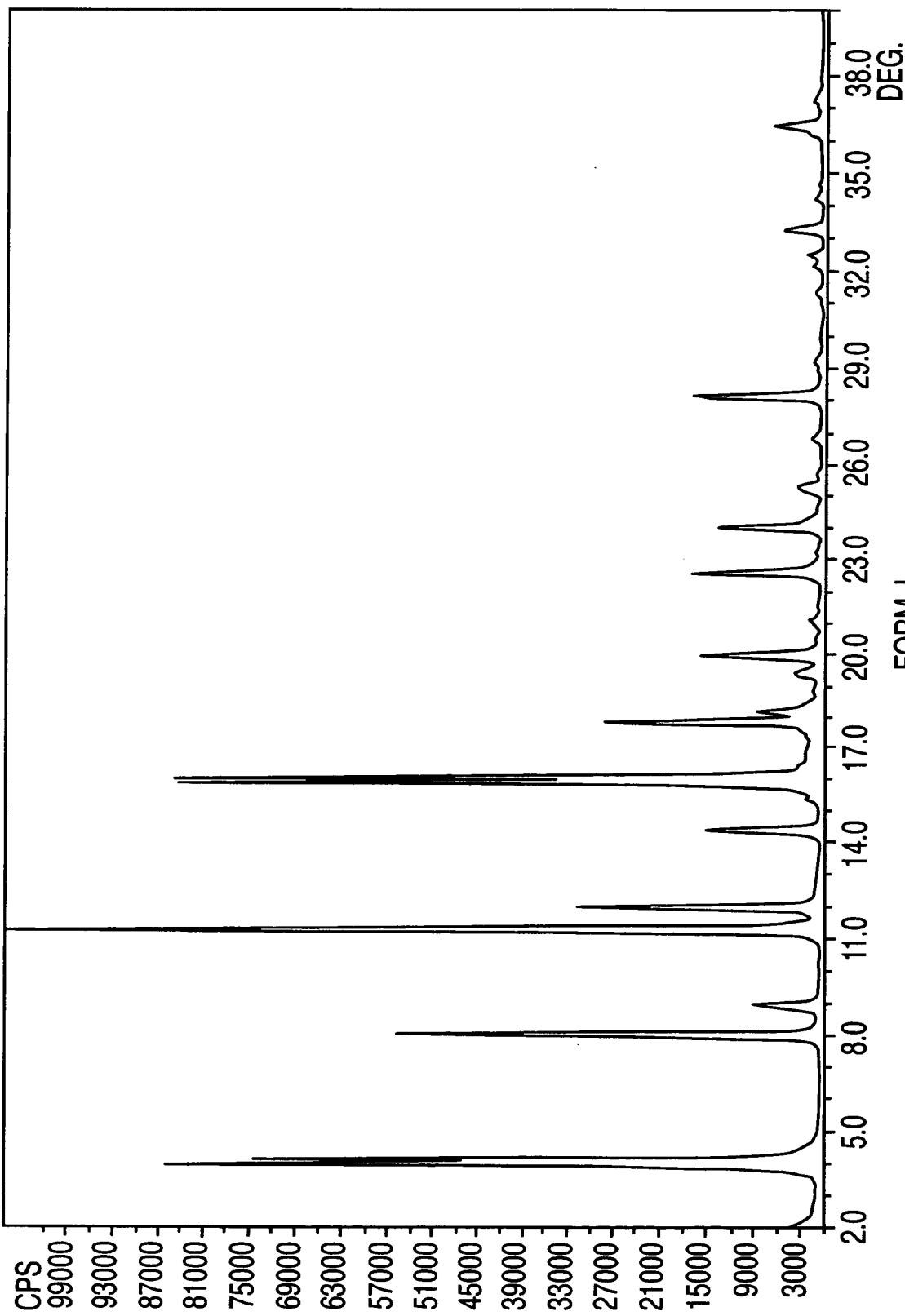
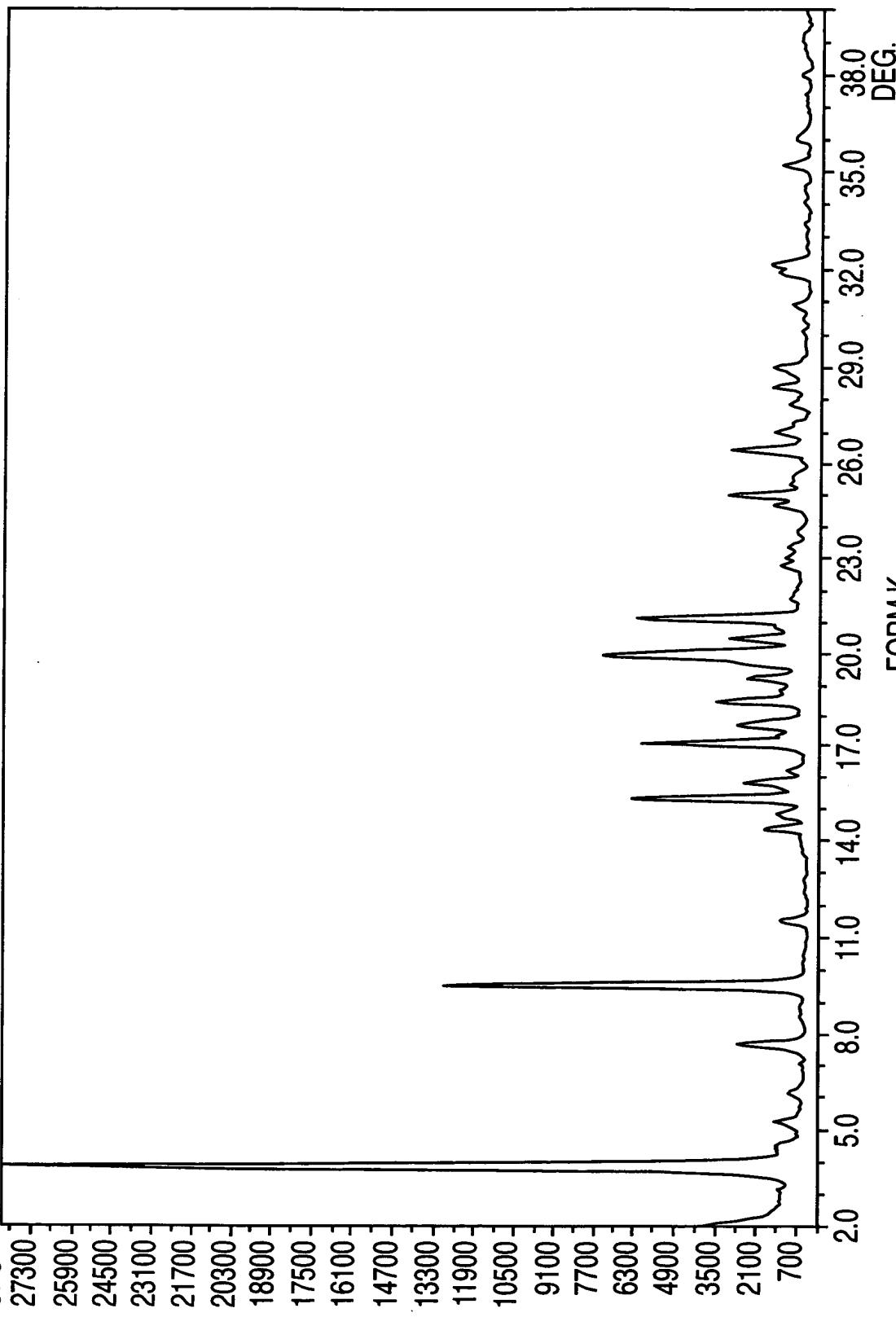


FIG. 8
FORM J

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



⊕

FIG. 9
FORM K

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

⊕

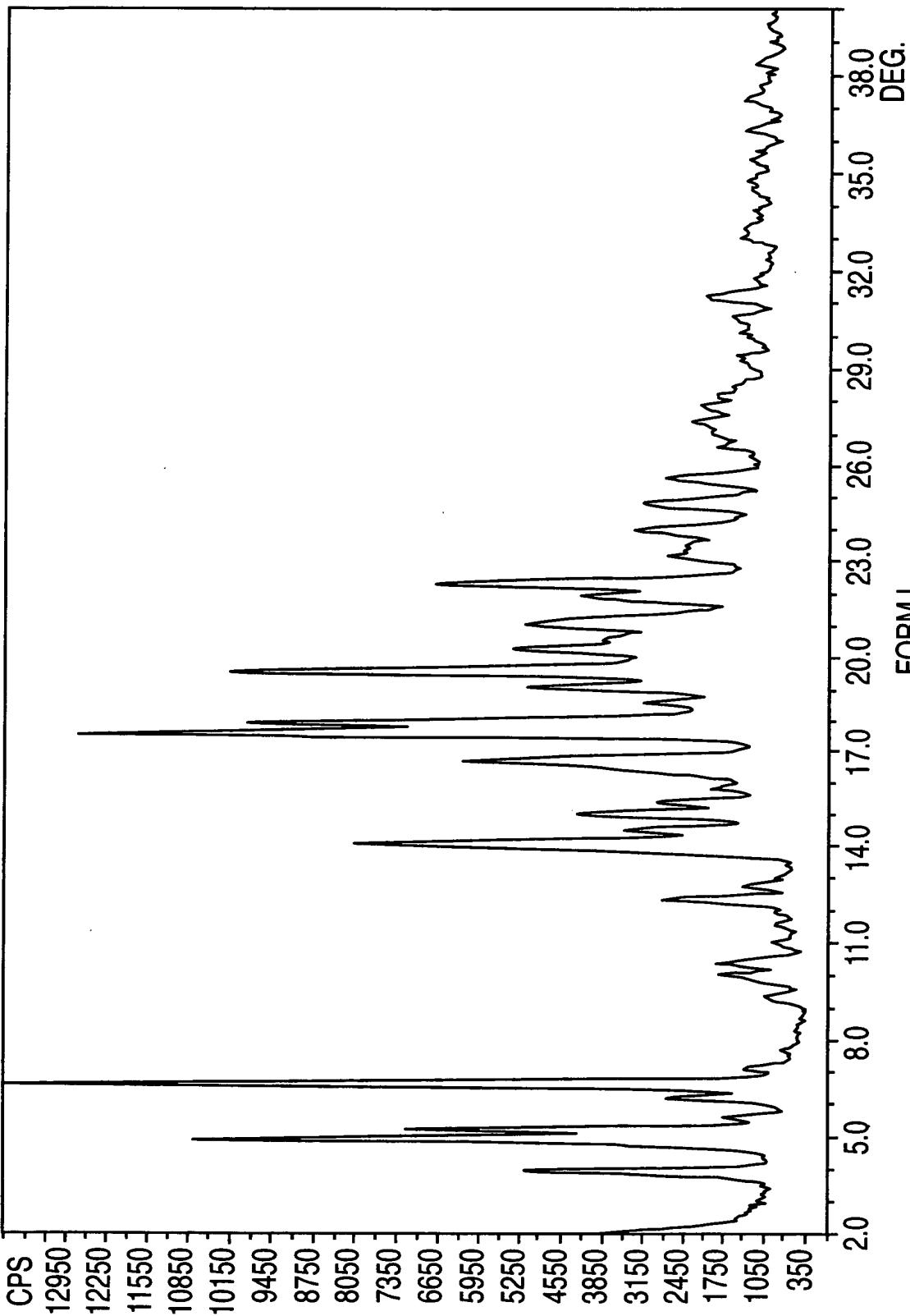


FIG. 10
FORM L

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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

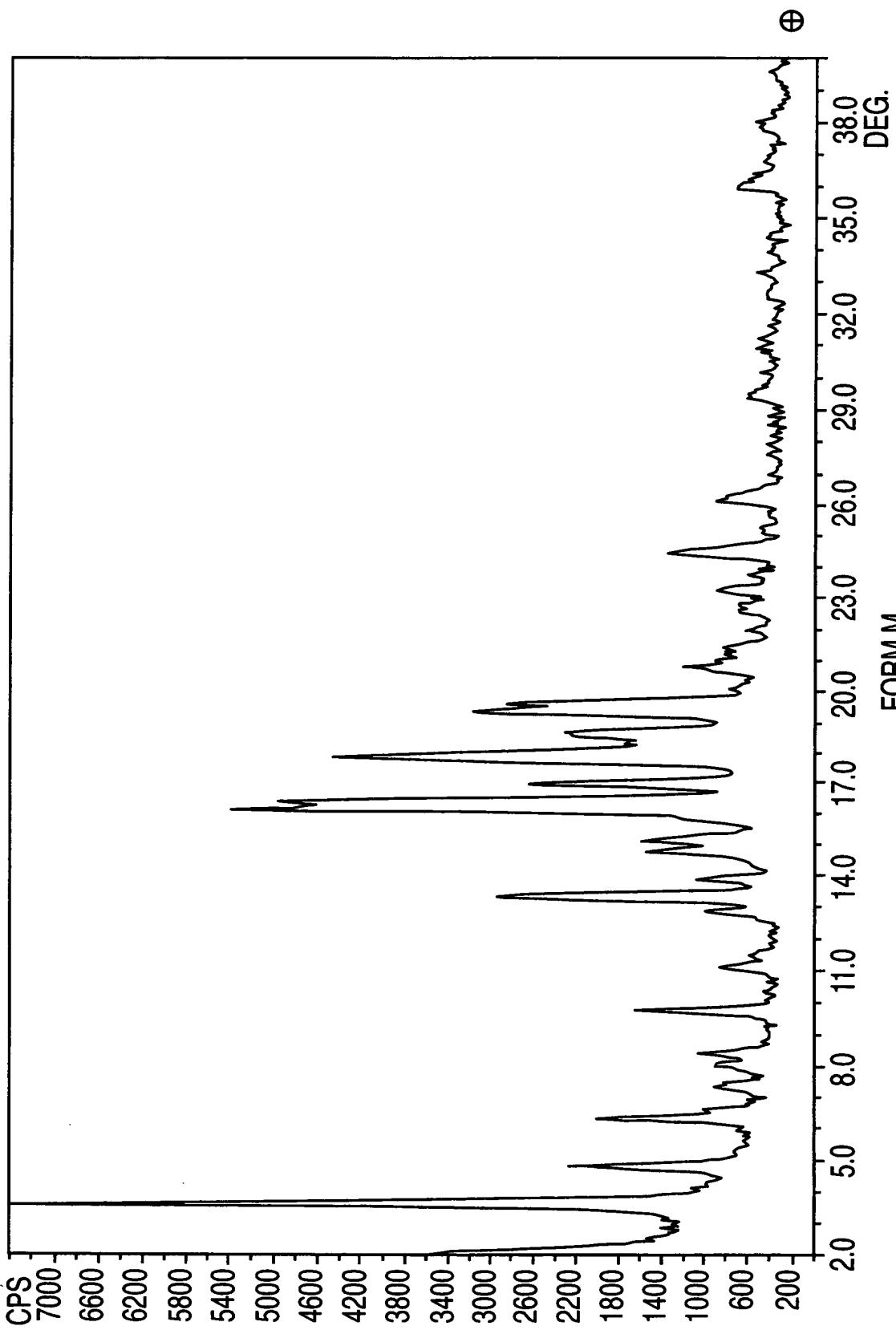


FIG. 11
FORM M

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⊕

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

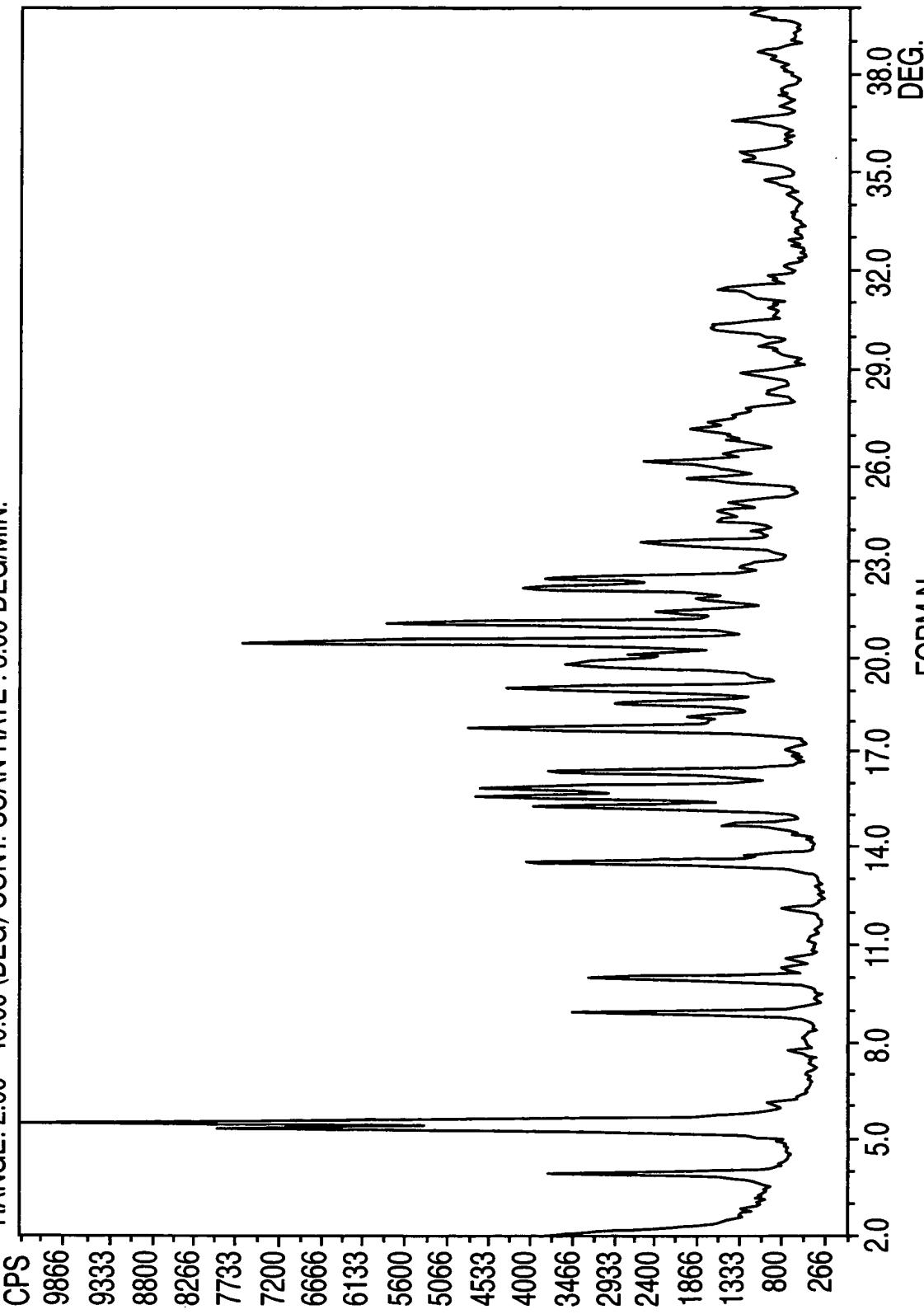
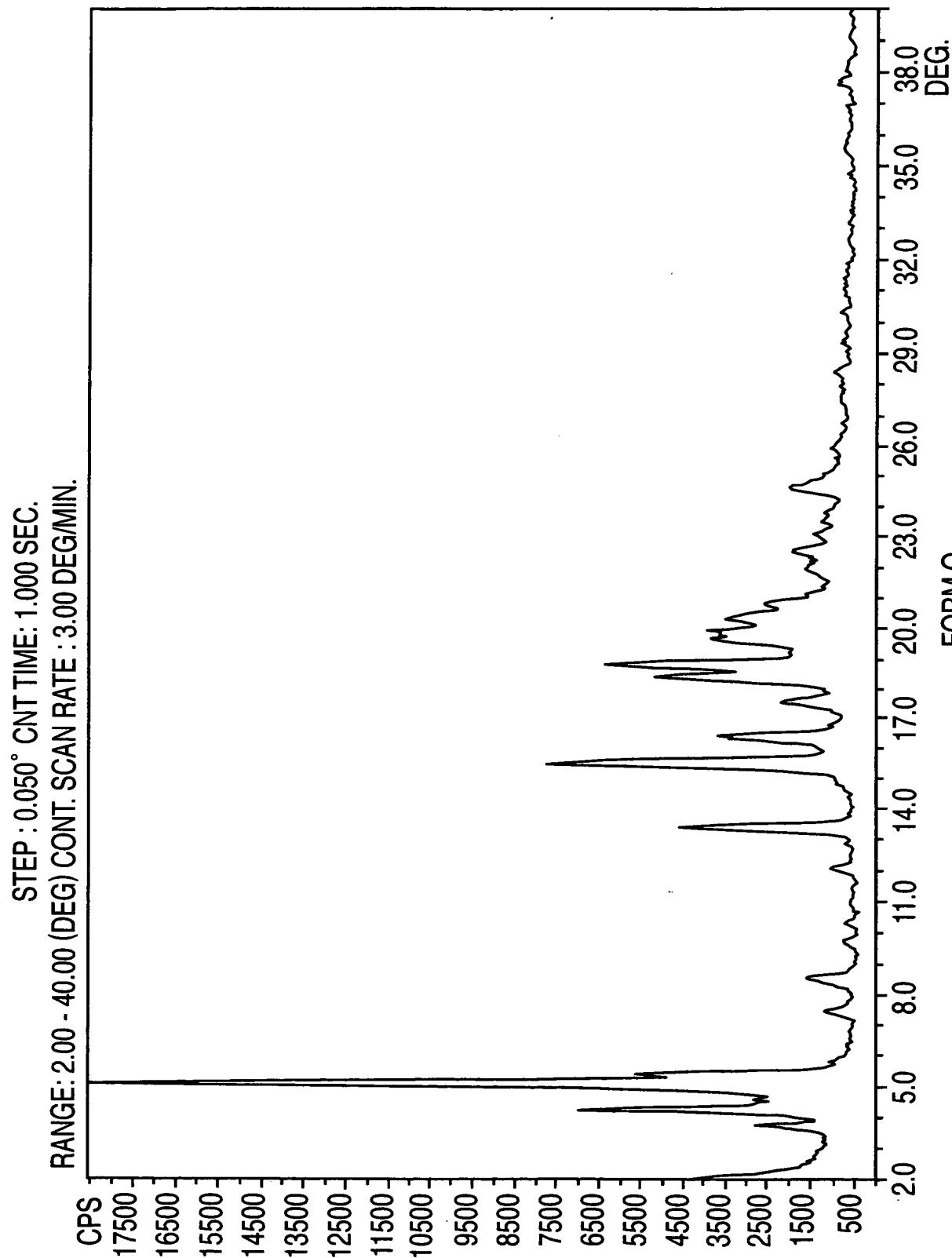


FIG. 12
FORM N

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8



FORM O
FIG. 13

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⊗

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

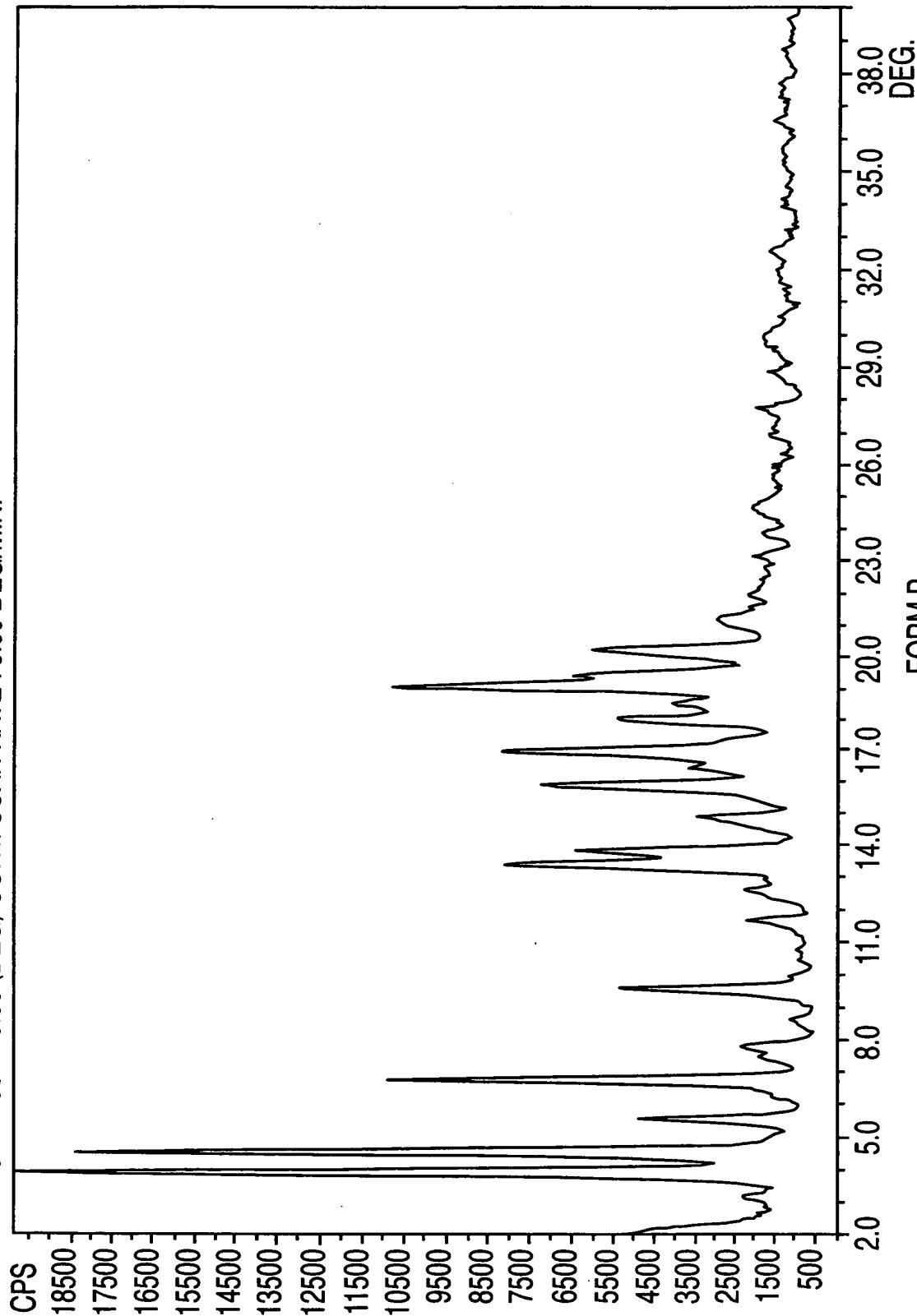


FIG. 14
FORM P

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⊗

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

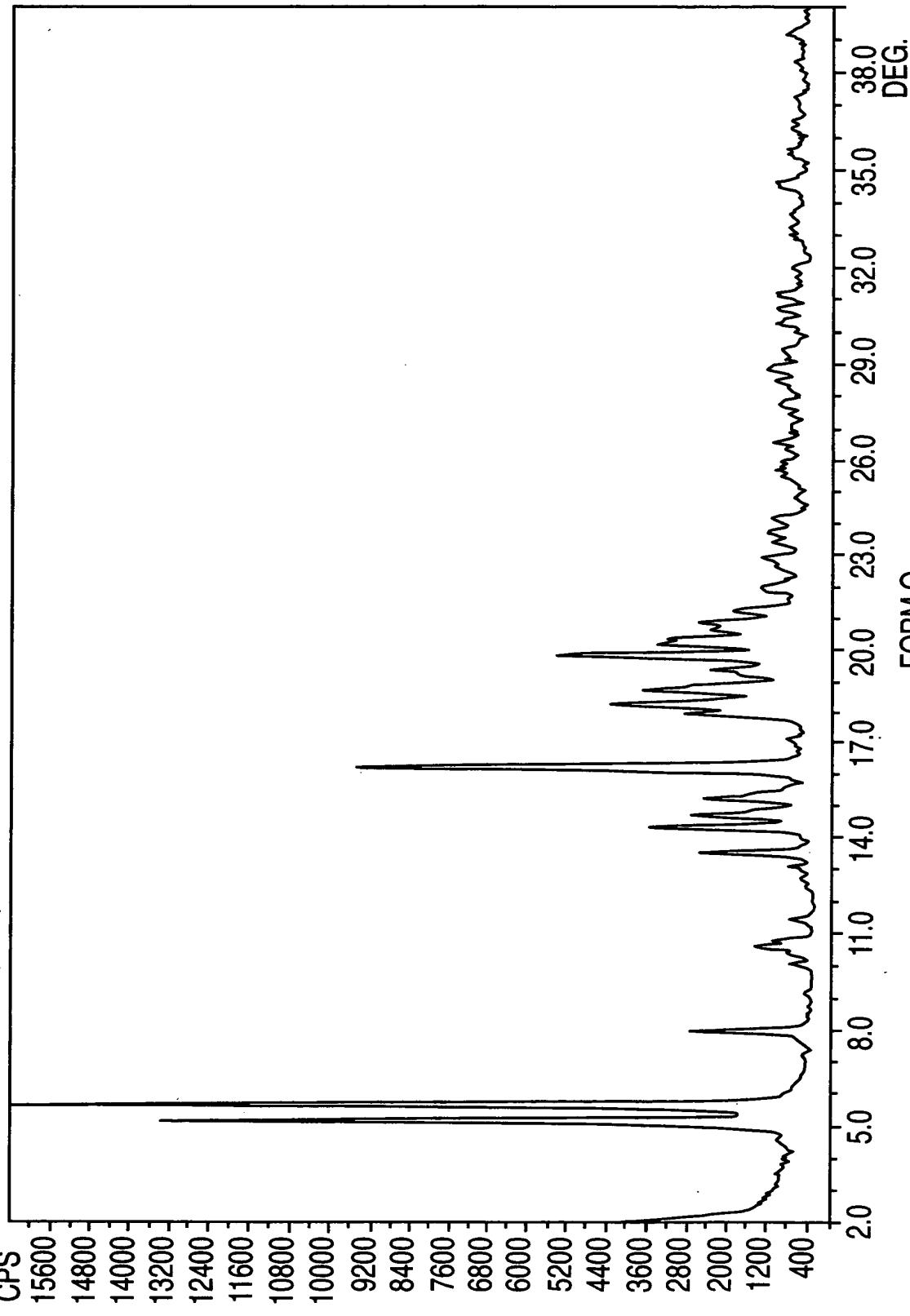


FIG. 15
FORM Q

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⊕

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

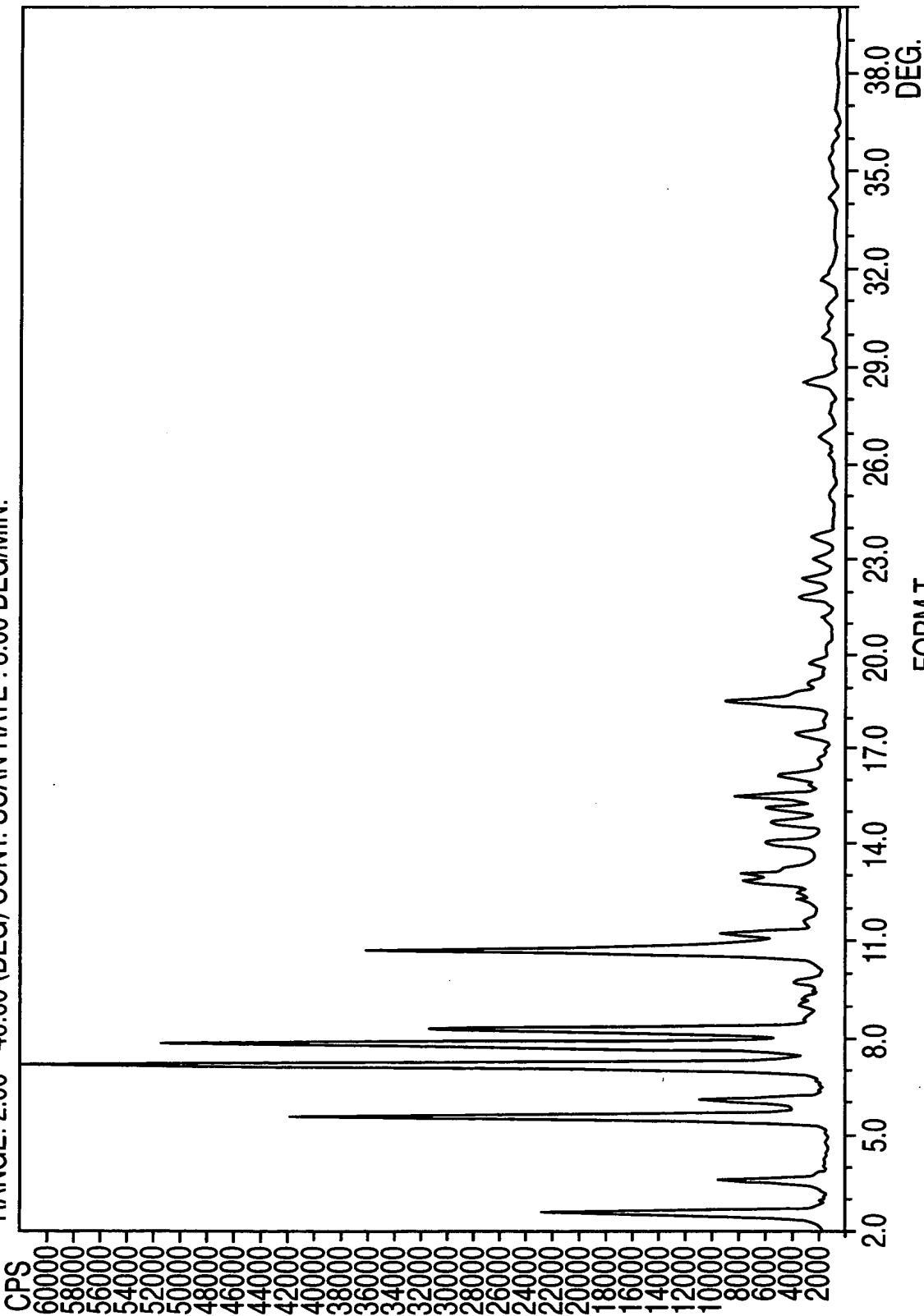


FIG. 16

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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

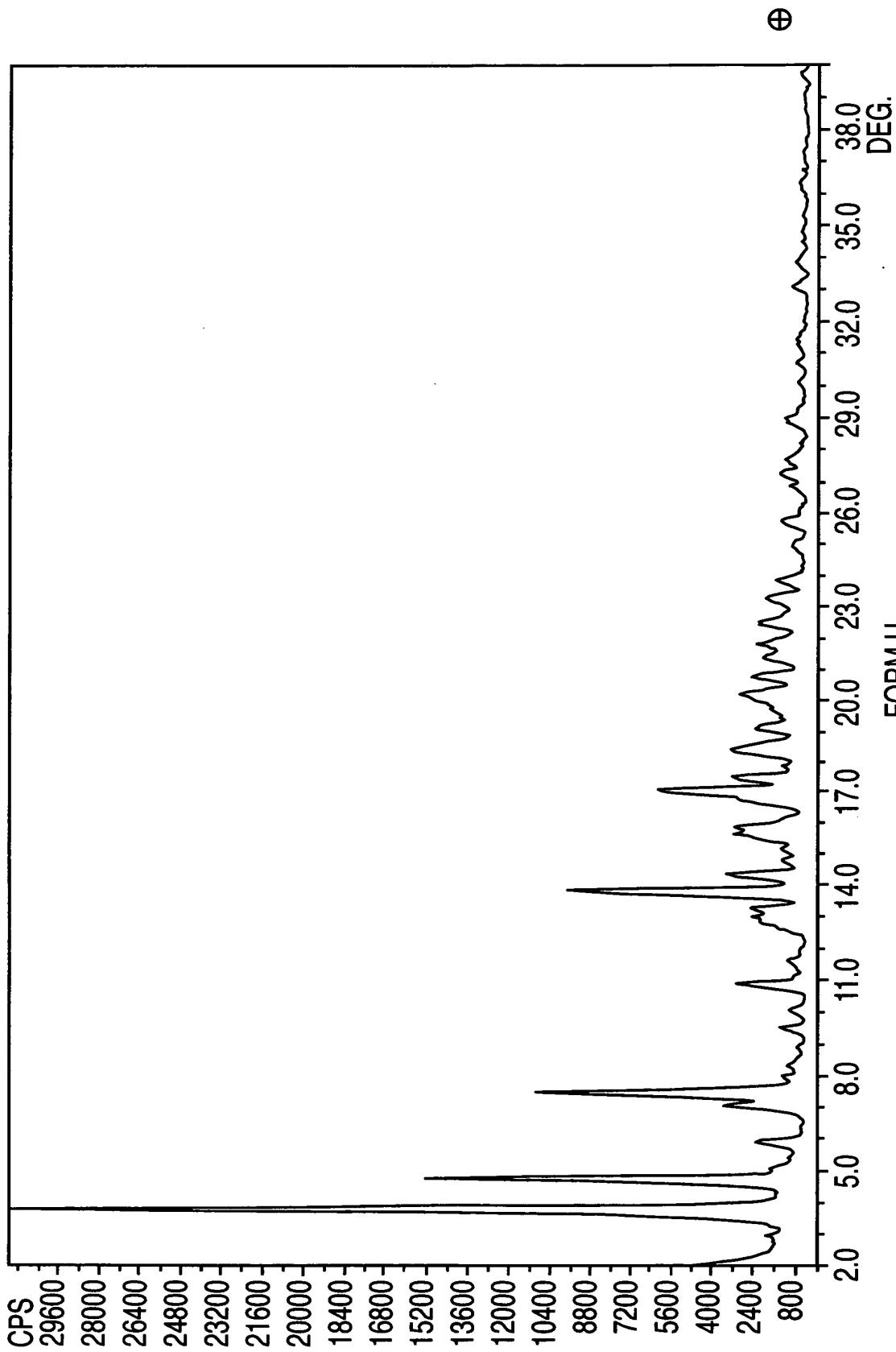


FIG. 17
FORM U

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⊕

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

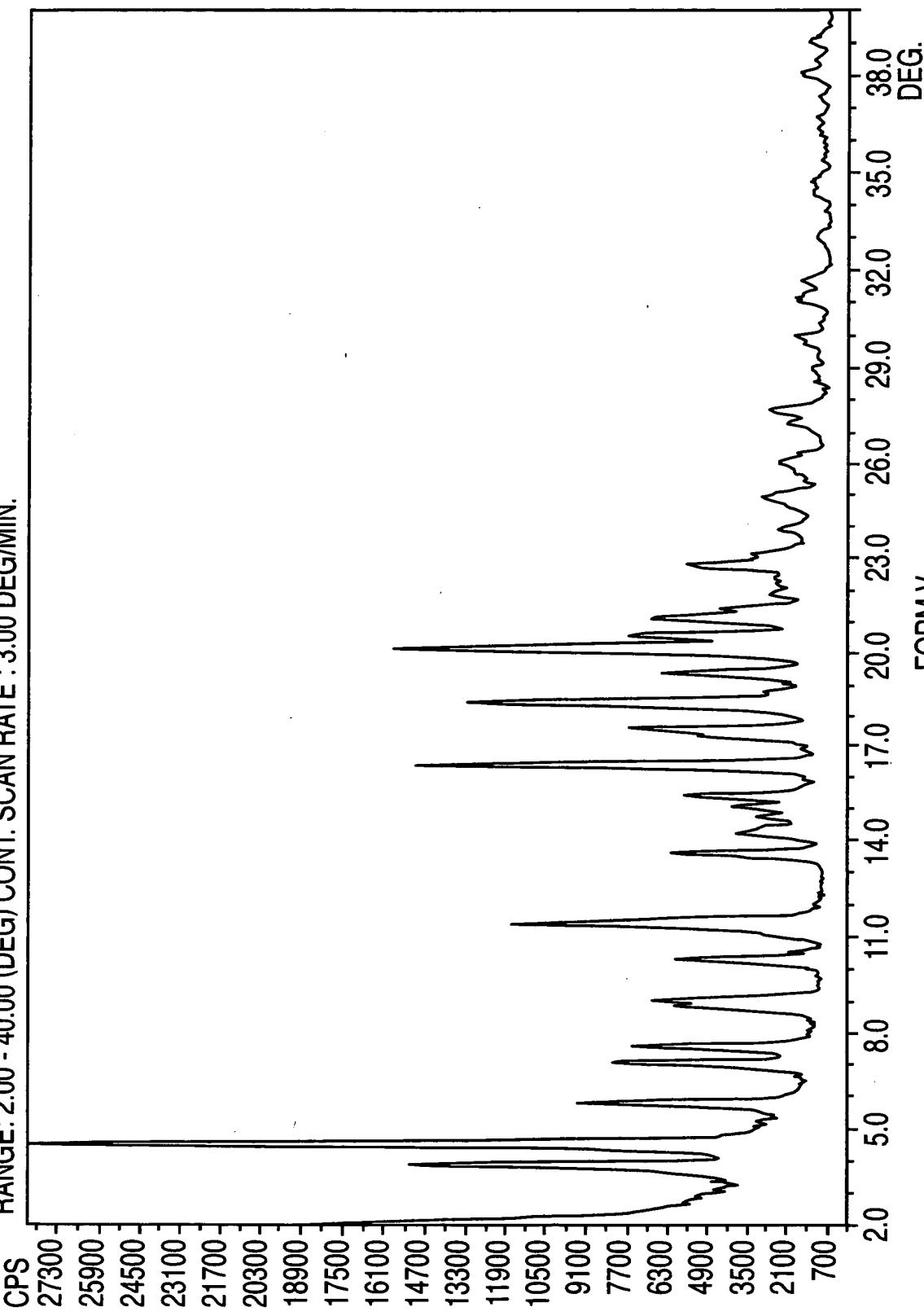
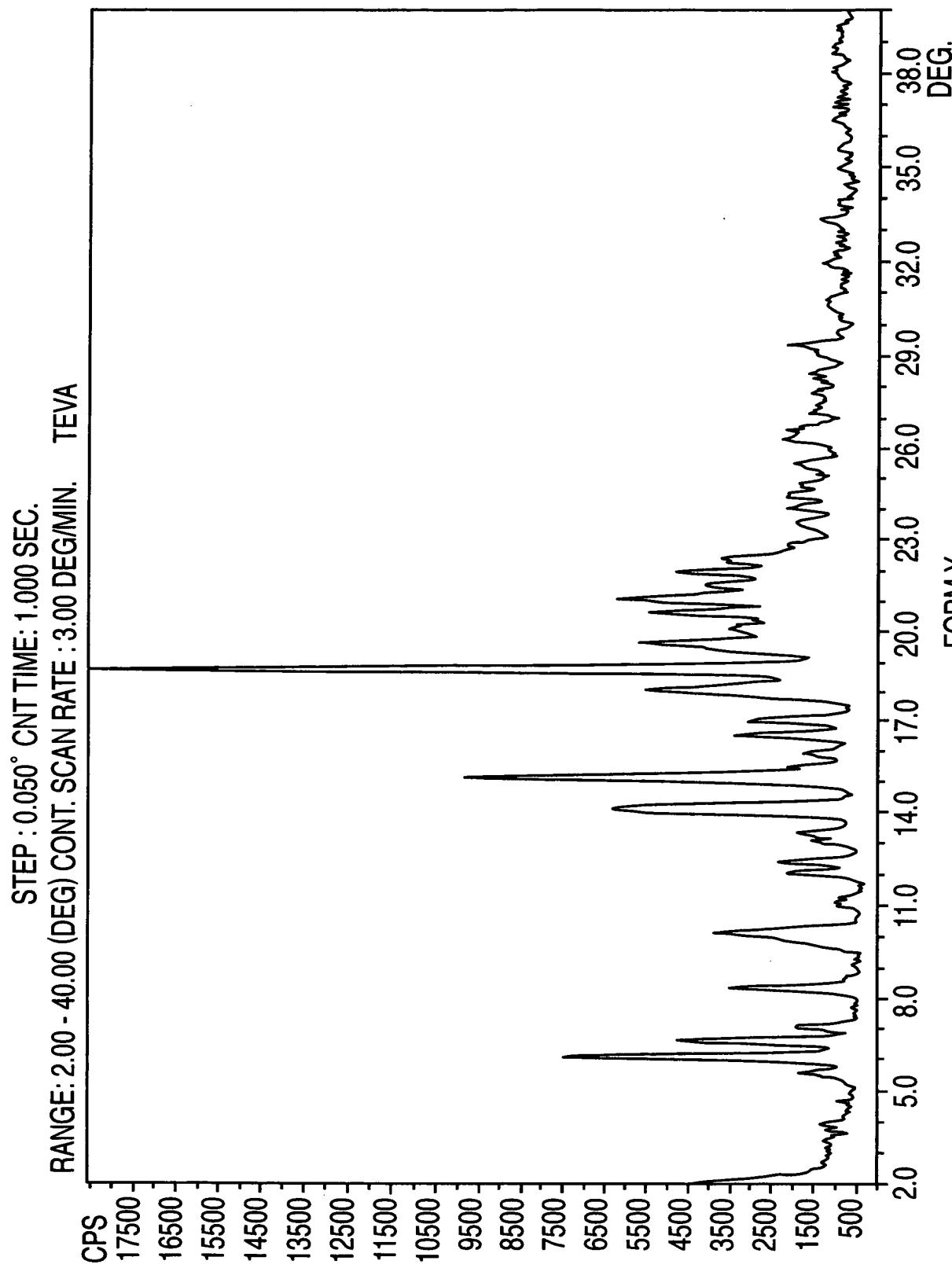
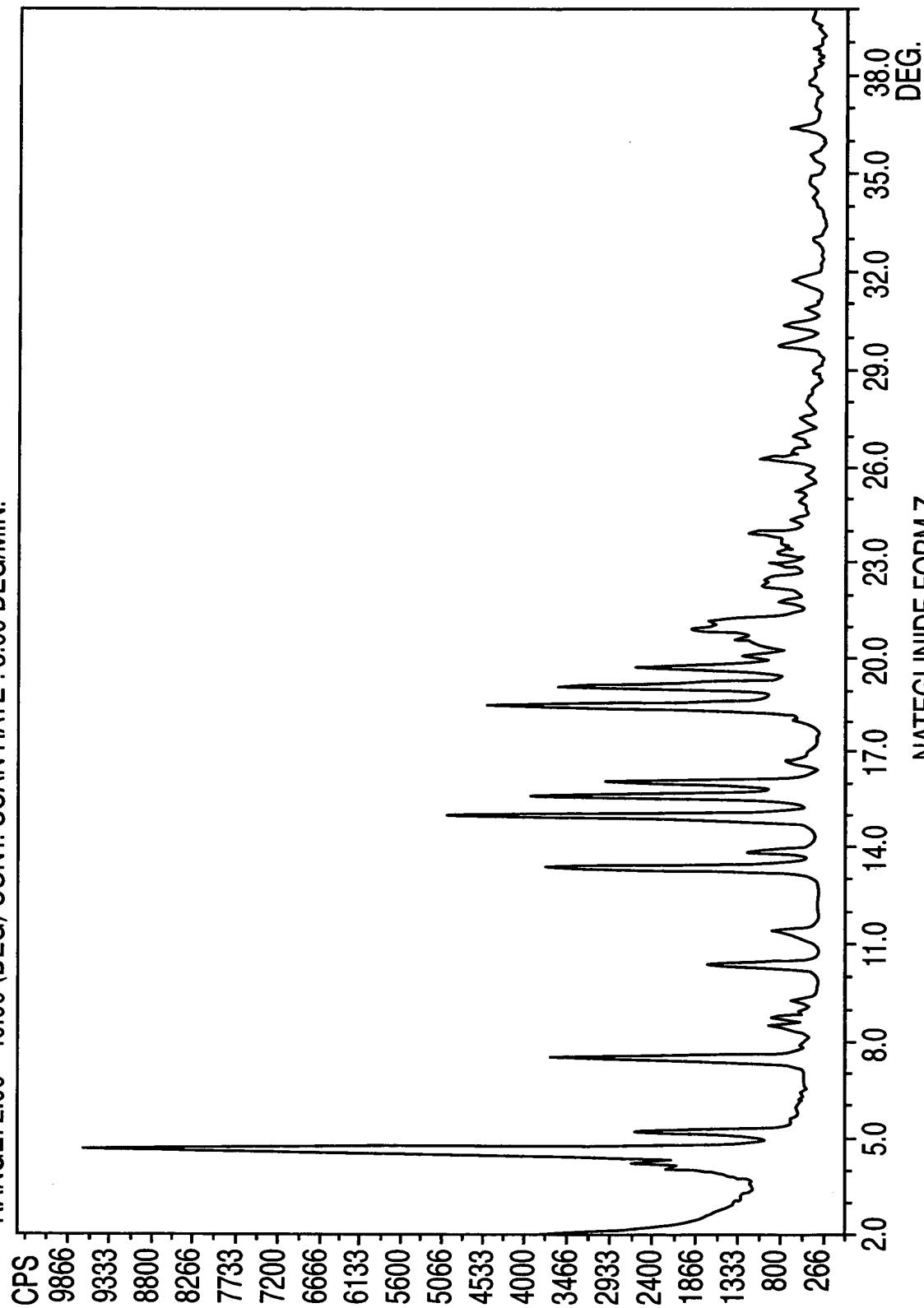


FIG. 18
FORM V



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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



NATEGLINIDE FORM Z
FIG. 20

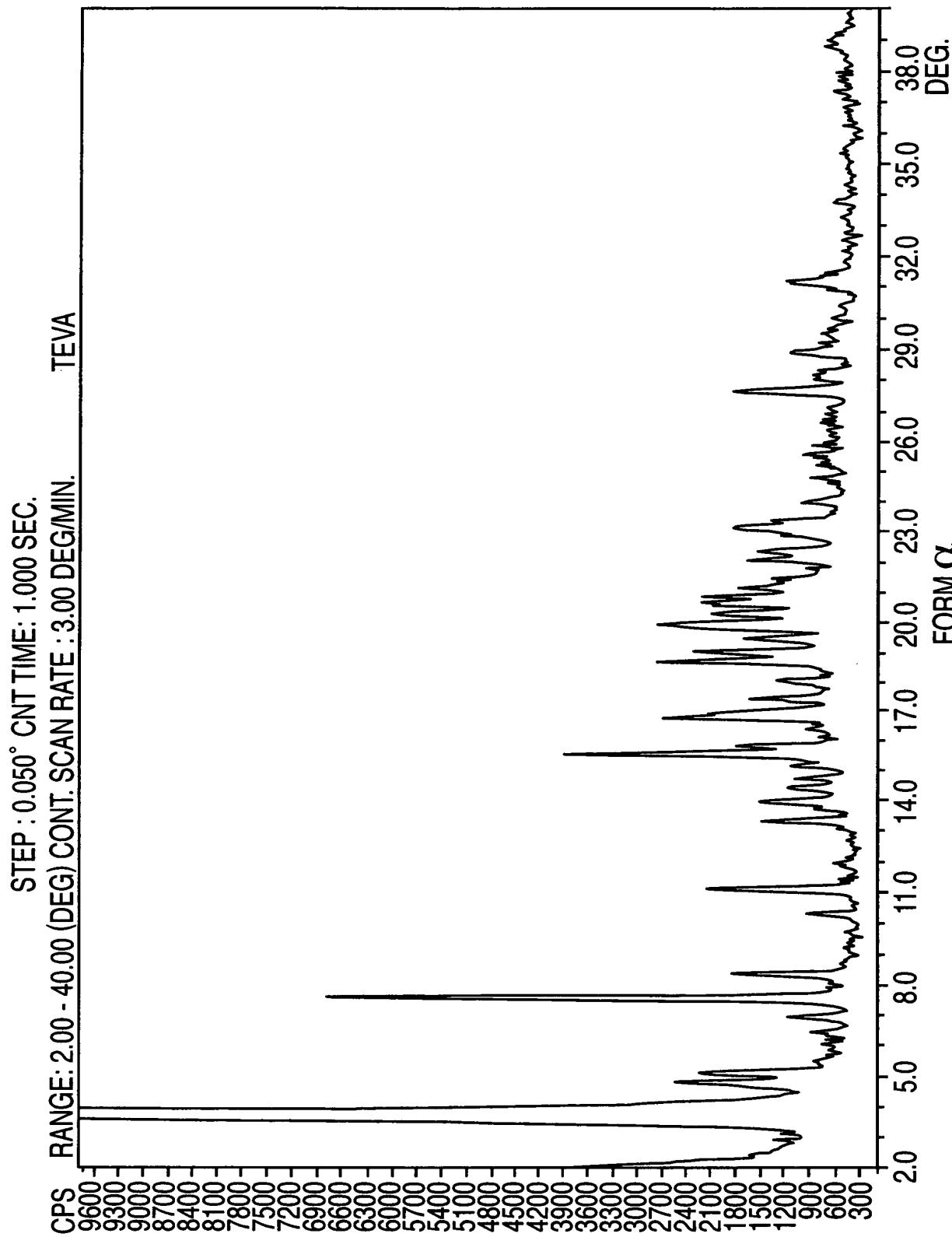


FIG. 21

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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN. TEVA

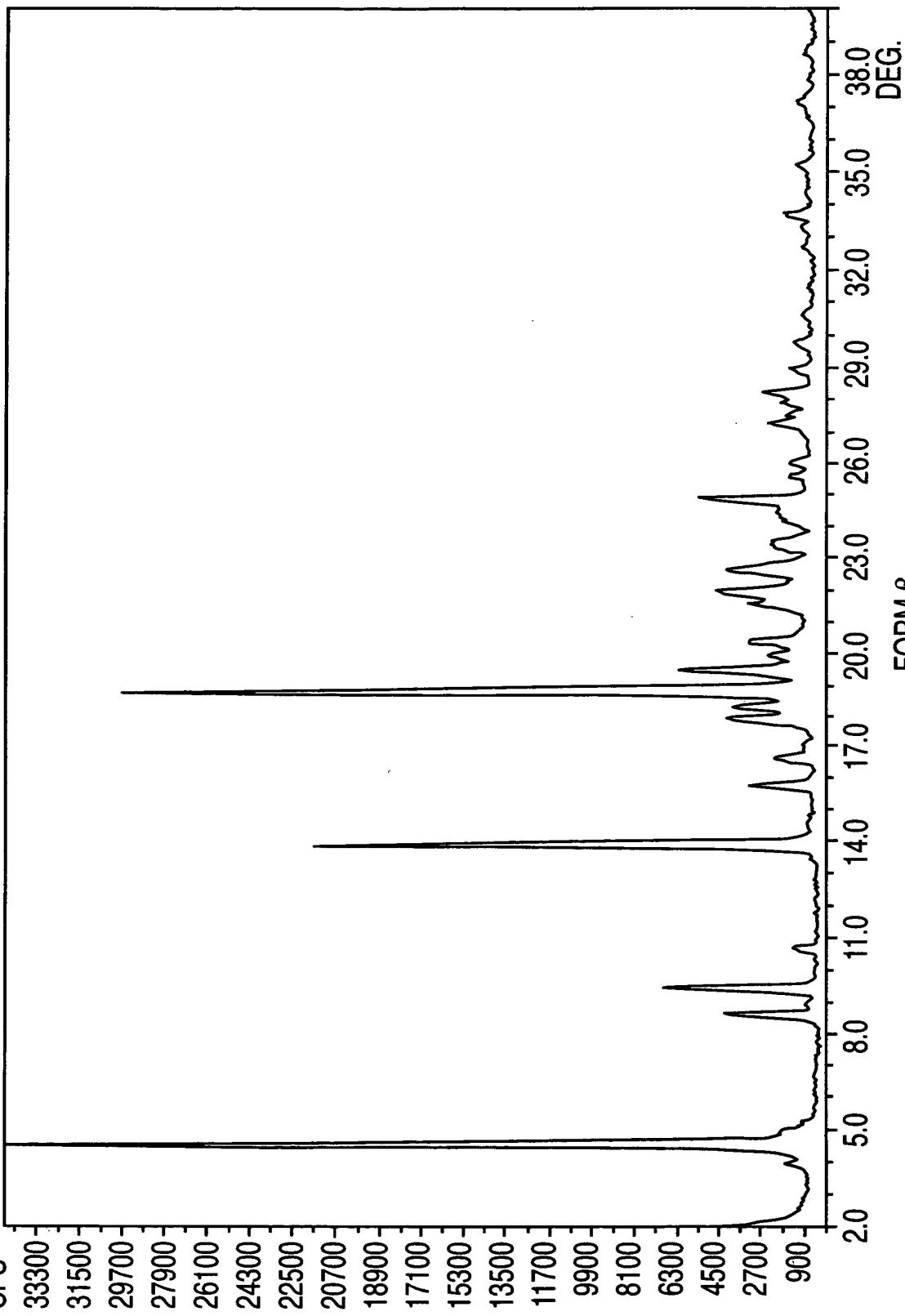


FIG. 22
FORM β

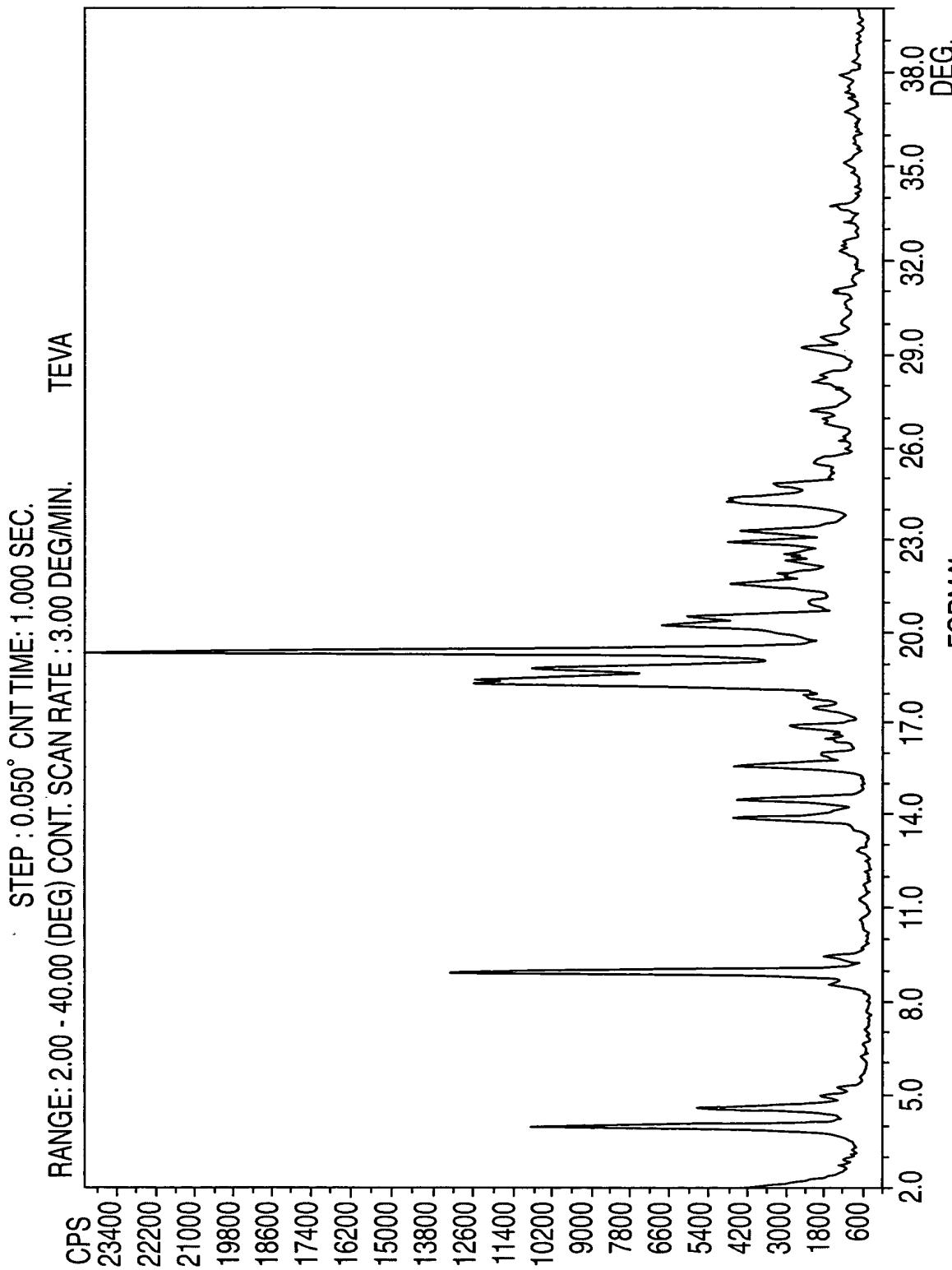


FIG. 23

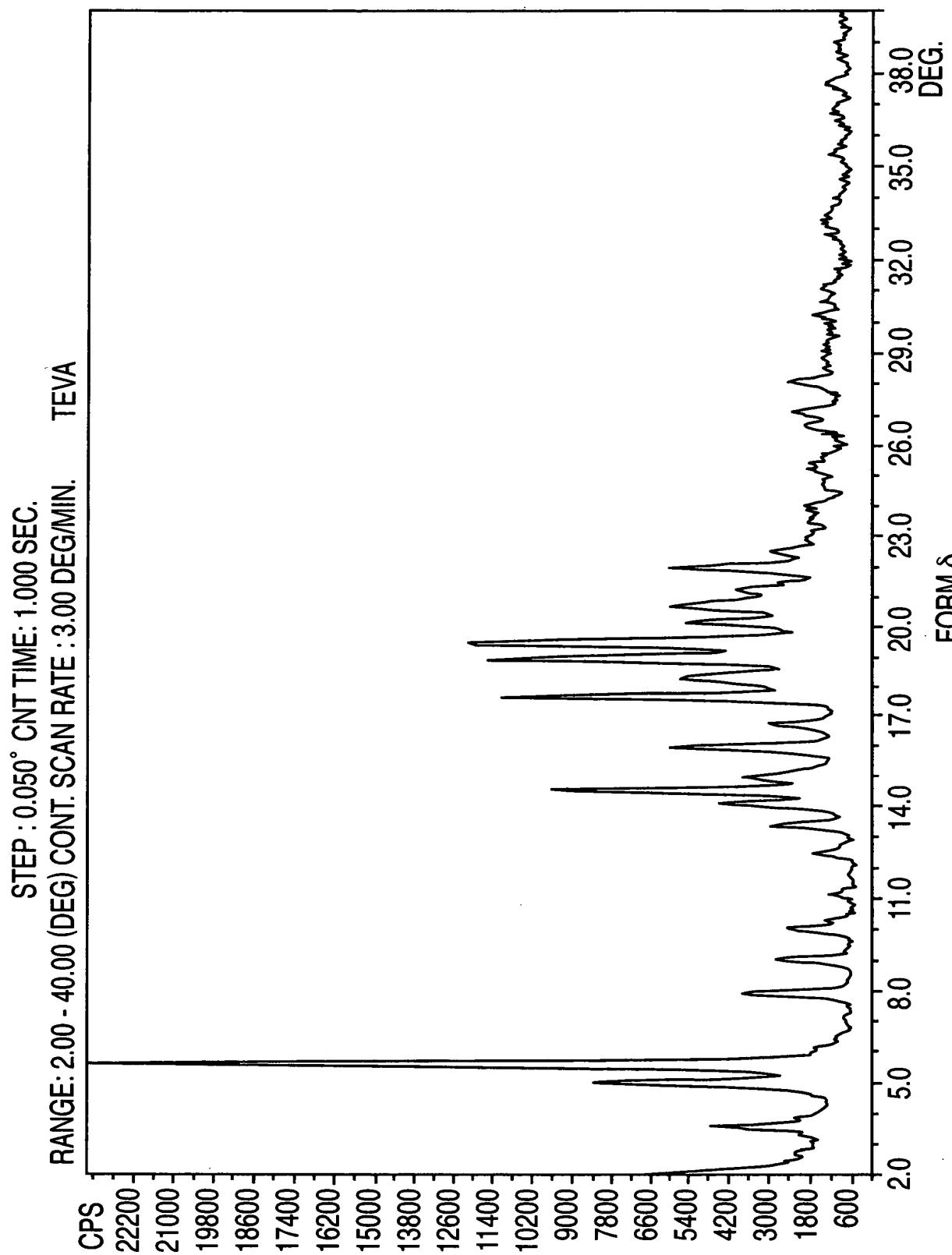


FIG. 24
FORM 8

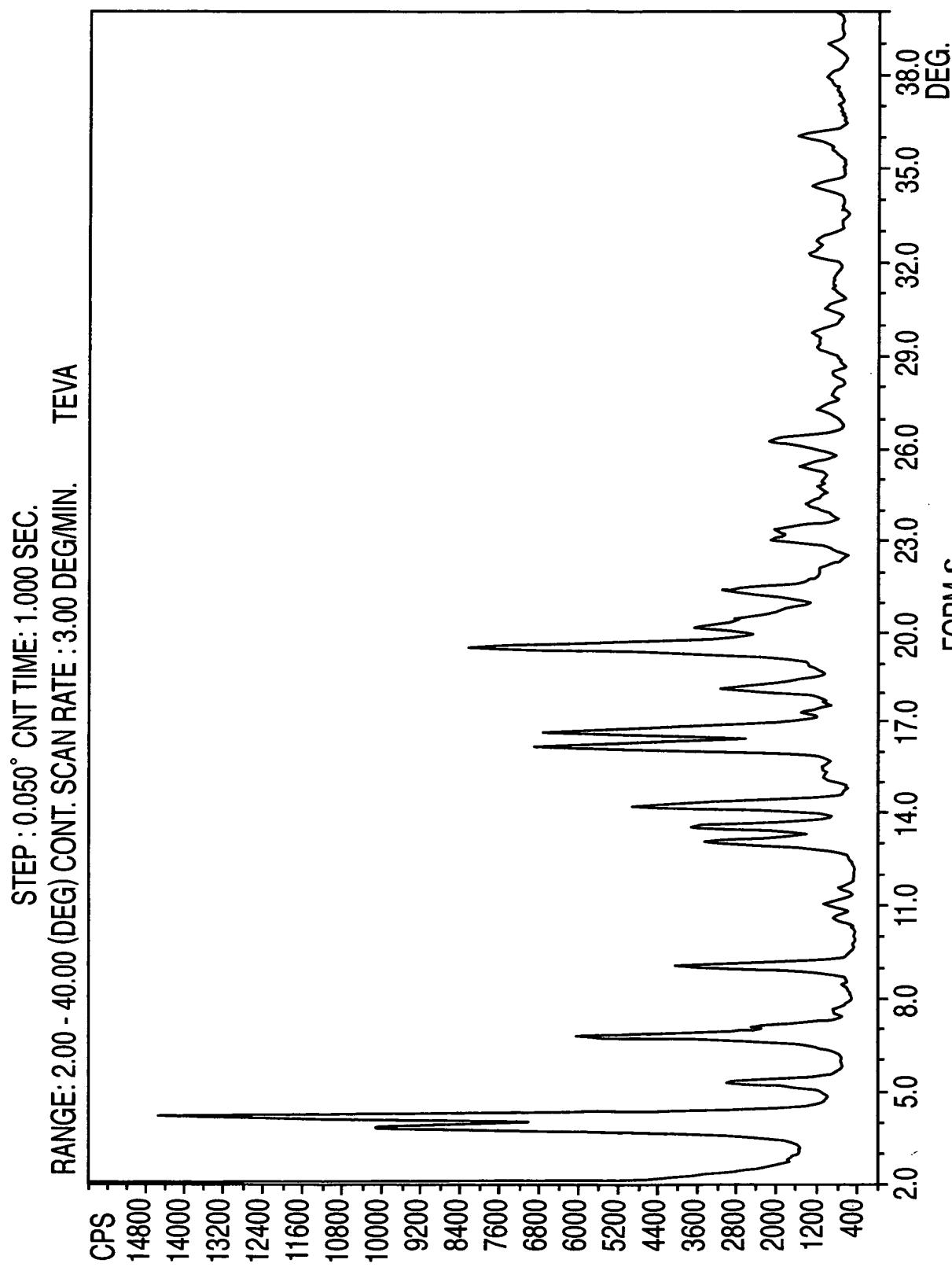


FIG. 25

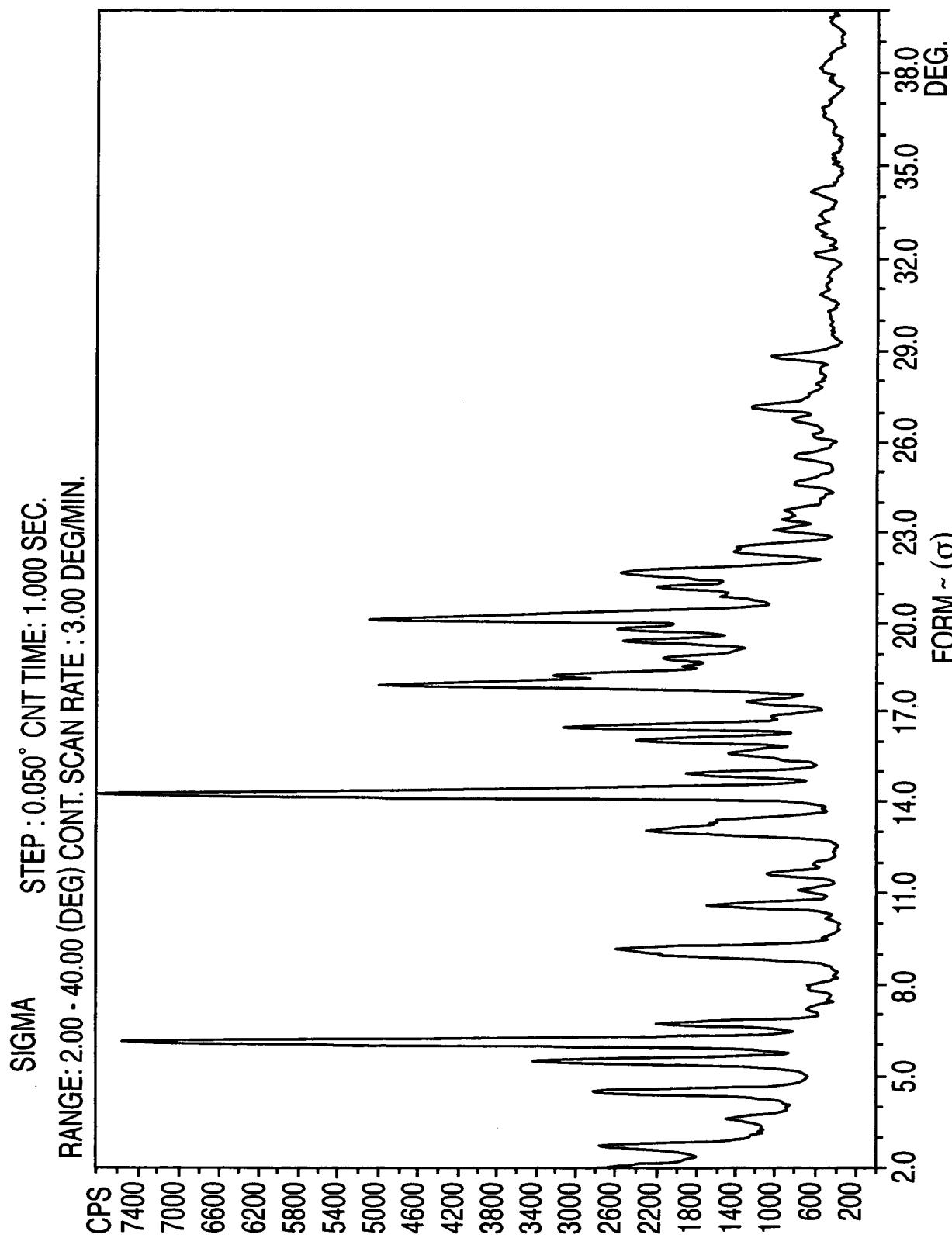


FIG. 26

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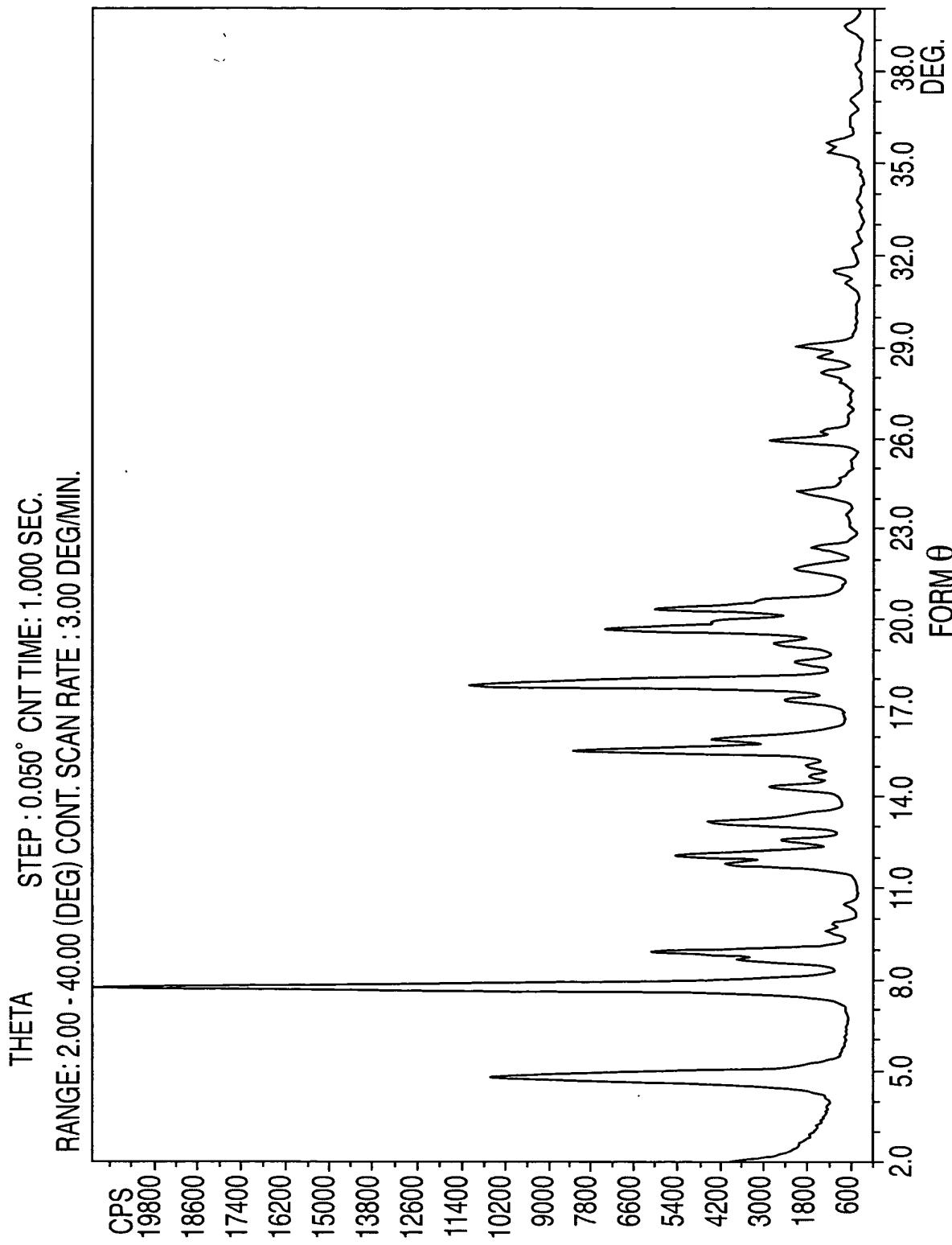


FIG. 27

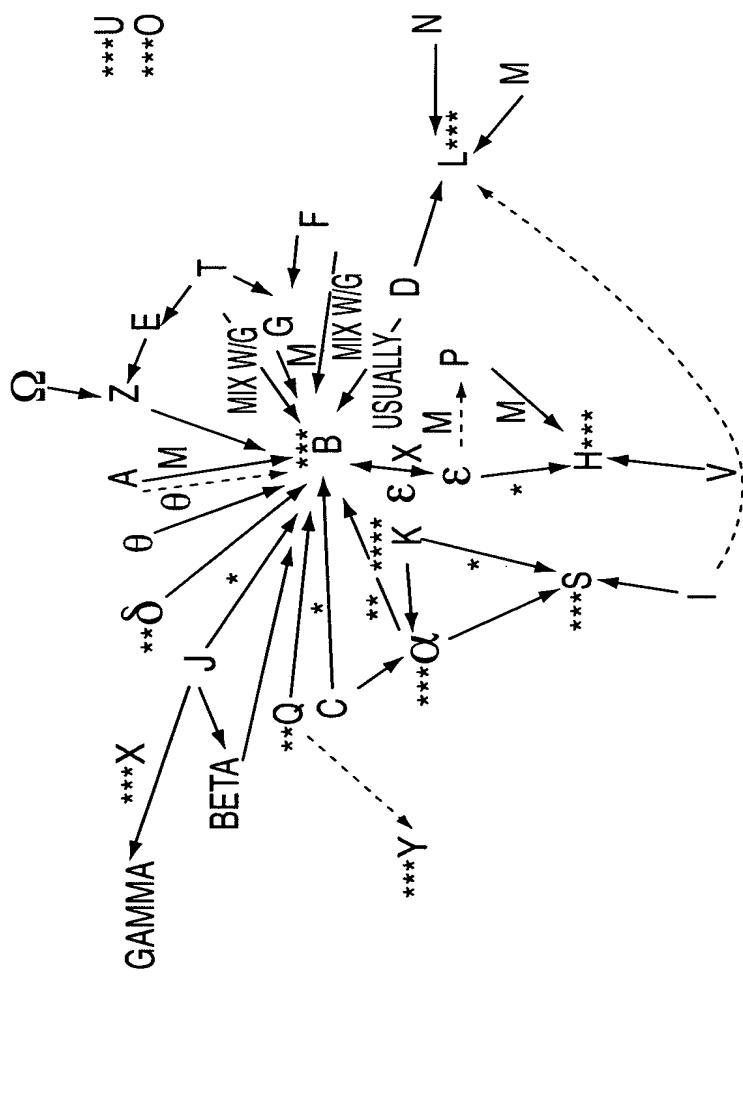
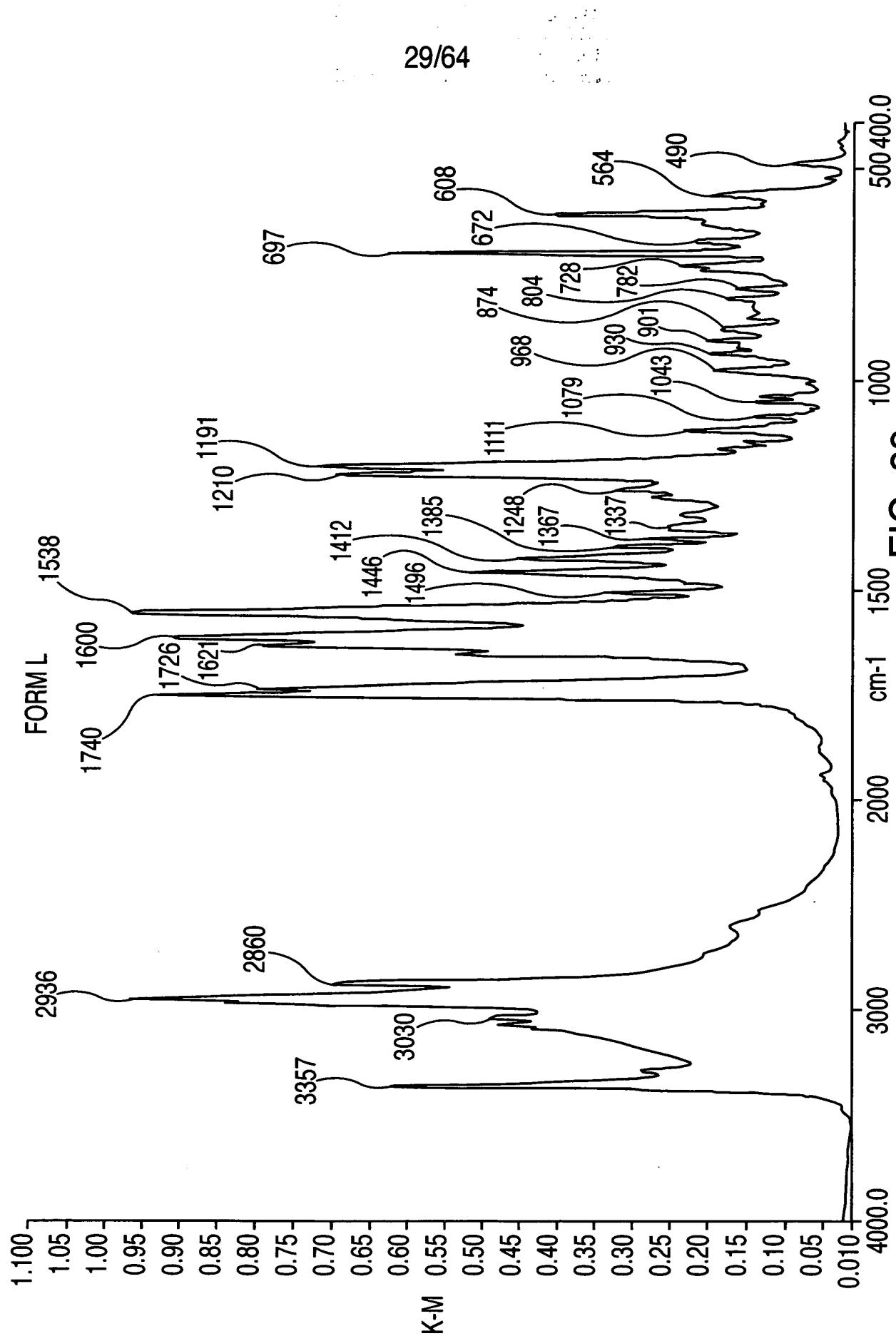


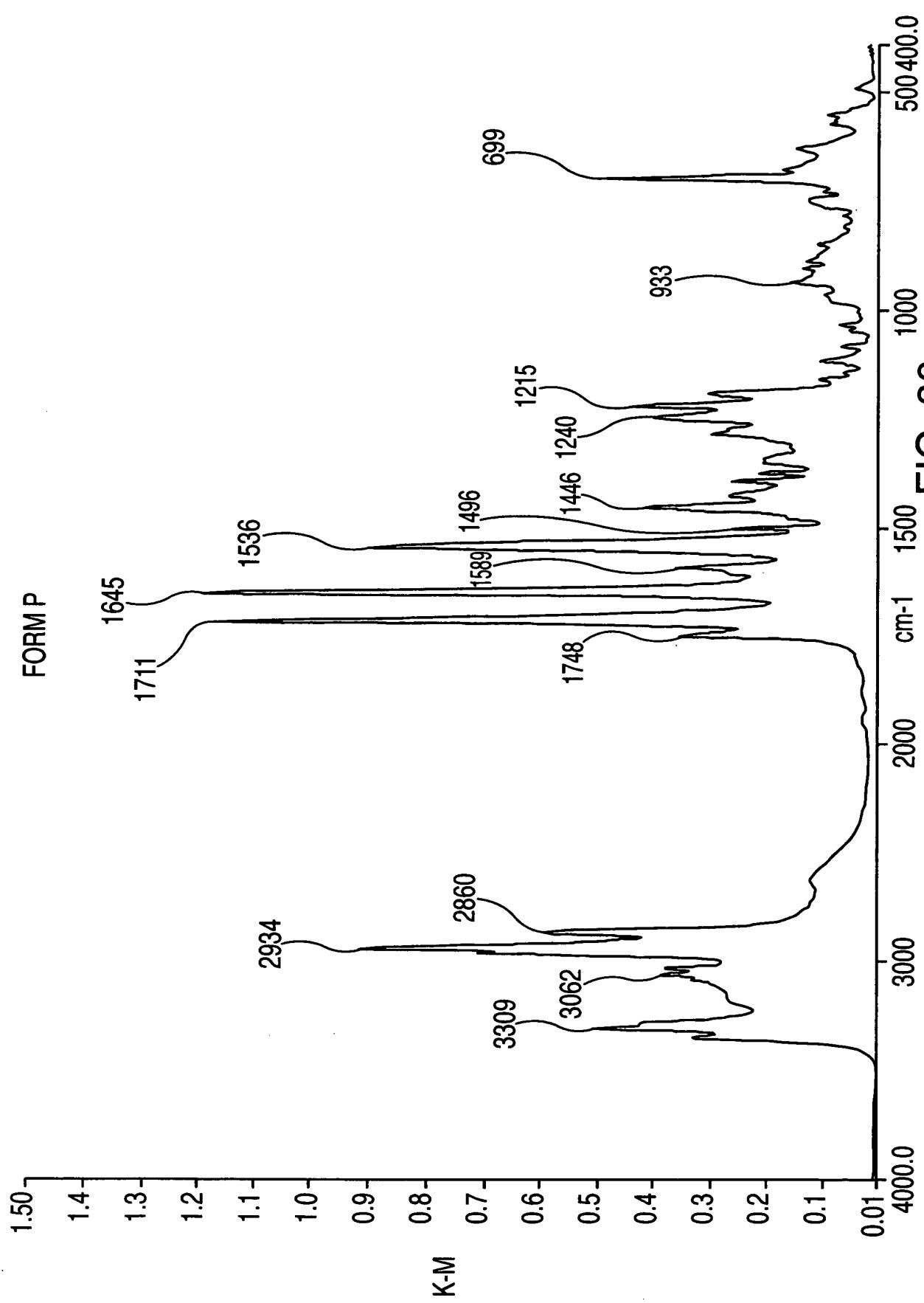
FIG. 28

THERMAL STABILITY CHART



-DRIFT, 4000-400 CM-1, 16 SCANS, RESOLUTION: 4.00 cm-1

FIG. 29



-DRIFT, 4000-400 CM-1, 16 SCANS, RESOLUTION: 4.00 cm-1

FIG. 30

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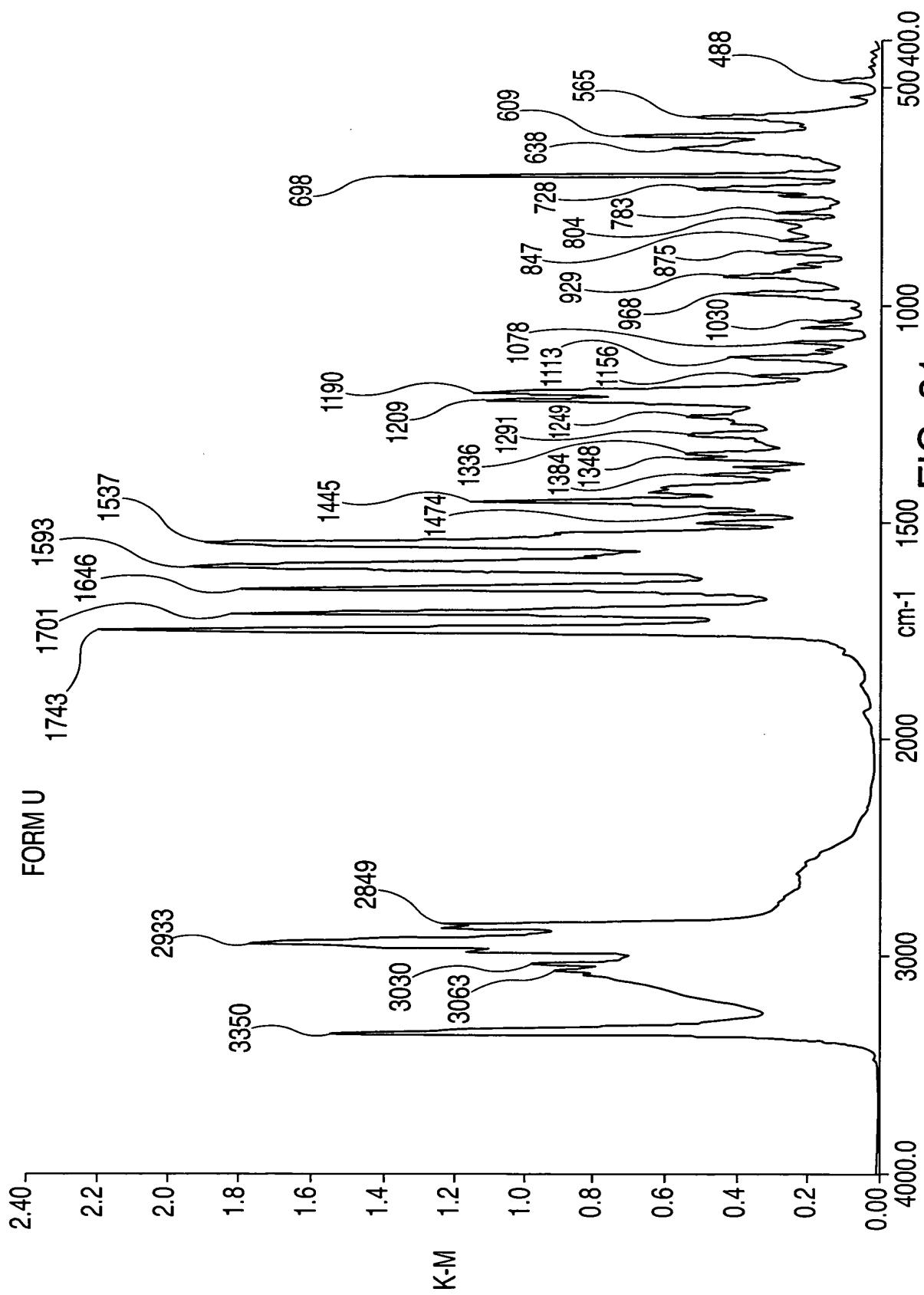
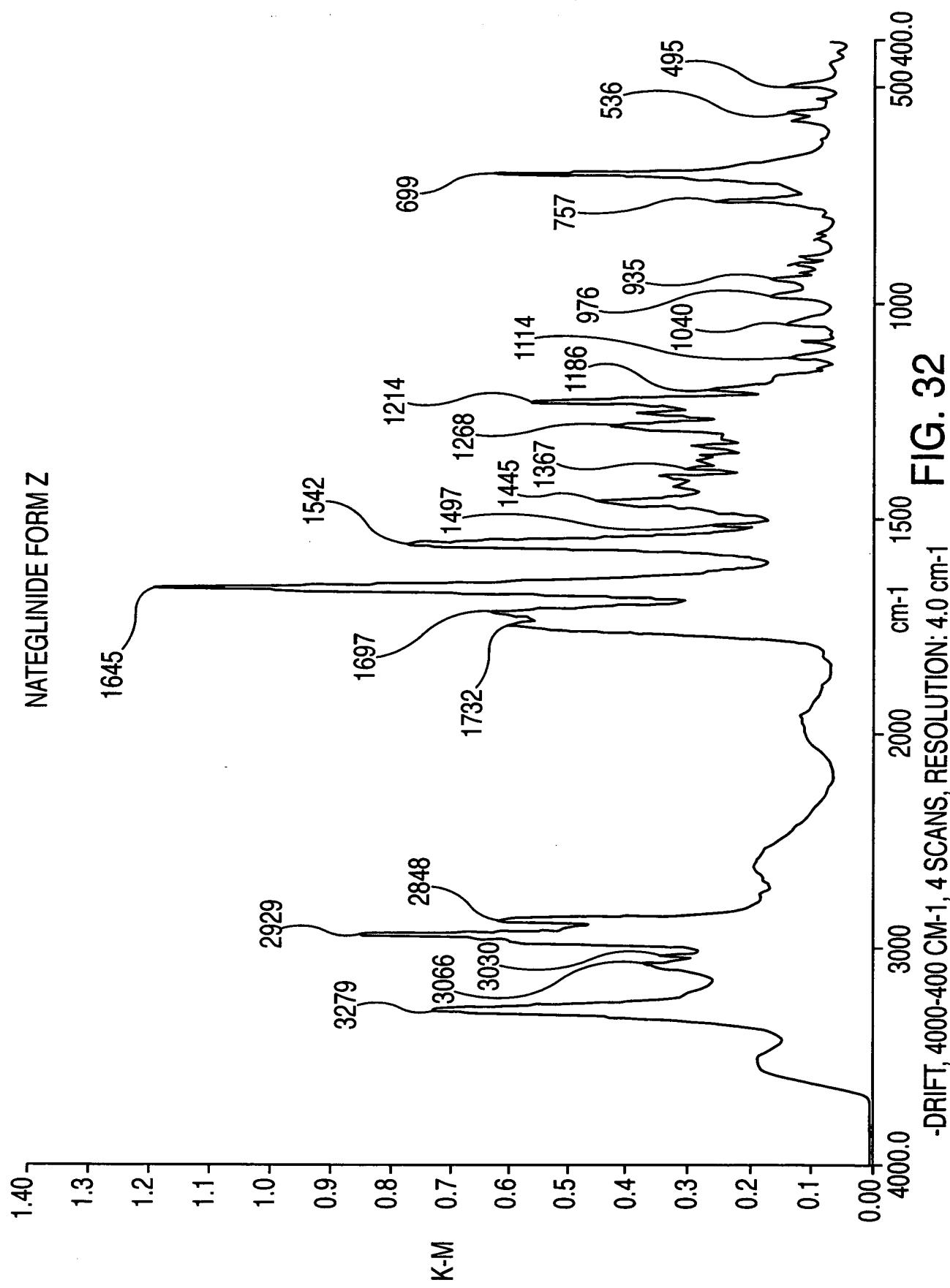


FIG. 31
-DRIFT, 4000-400 cm^{-1} , 16 SCANS, RESOLUTION: 4.0 cm^{-1}

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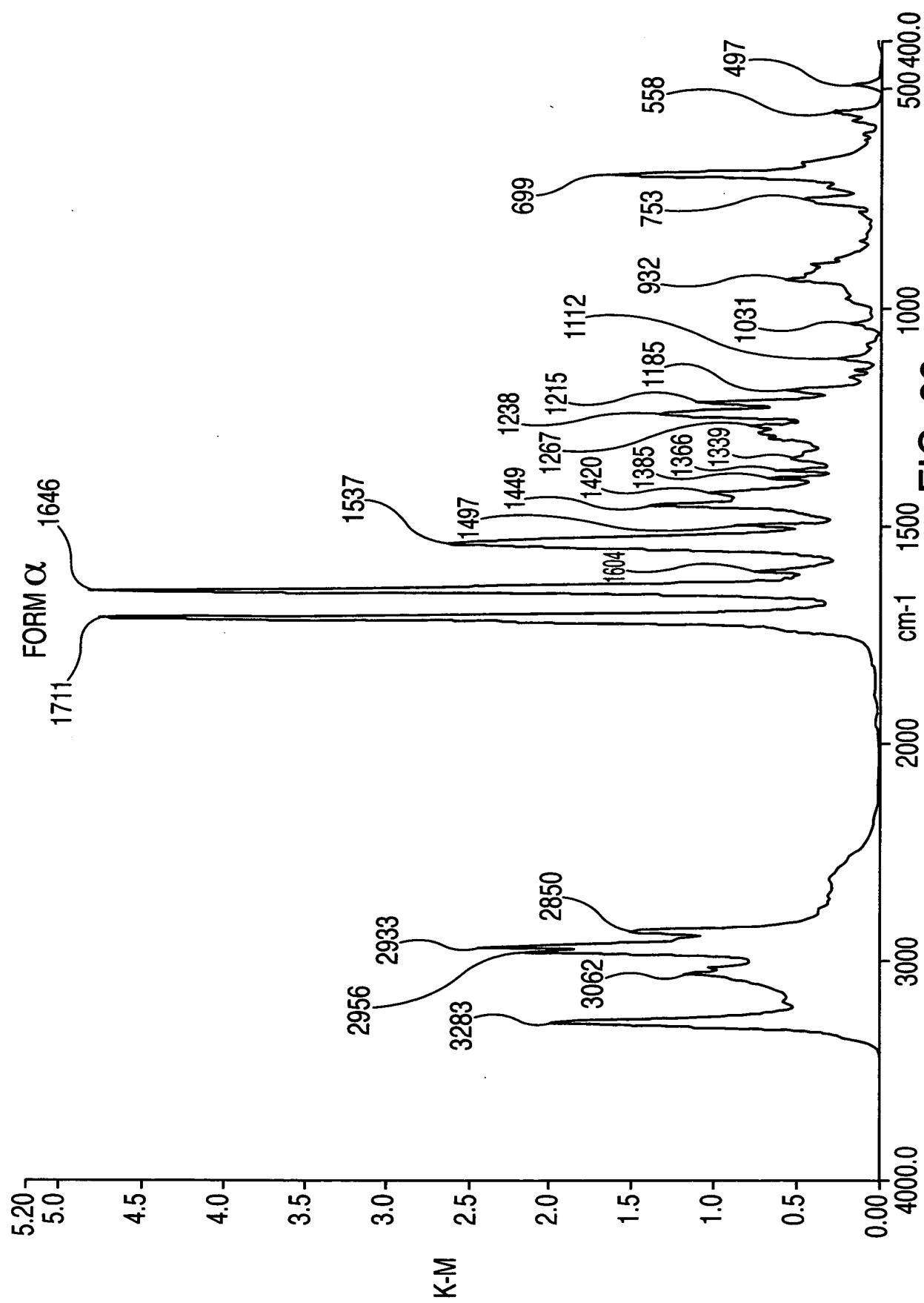
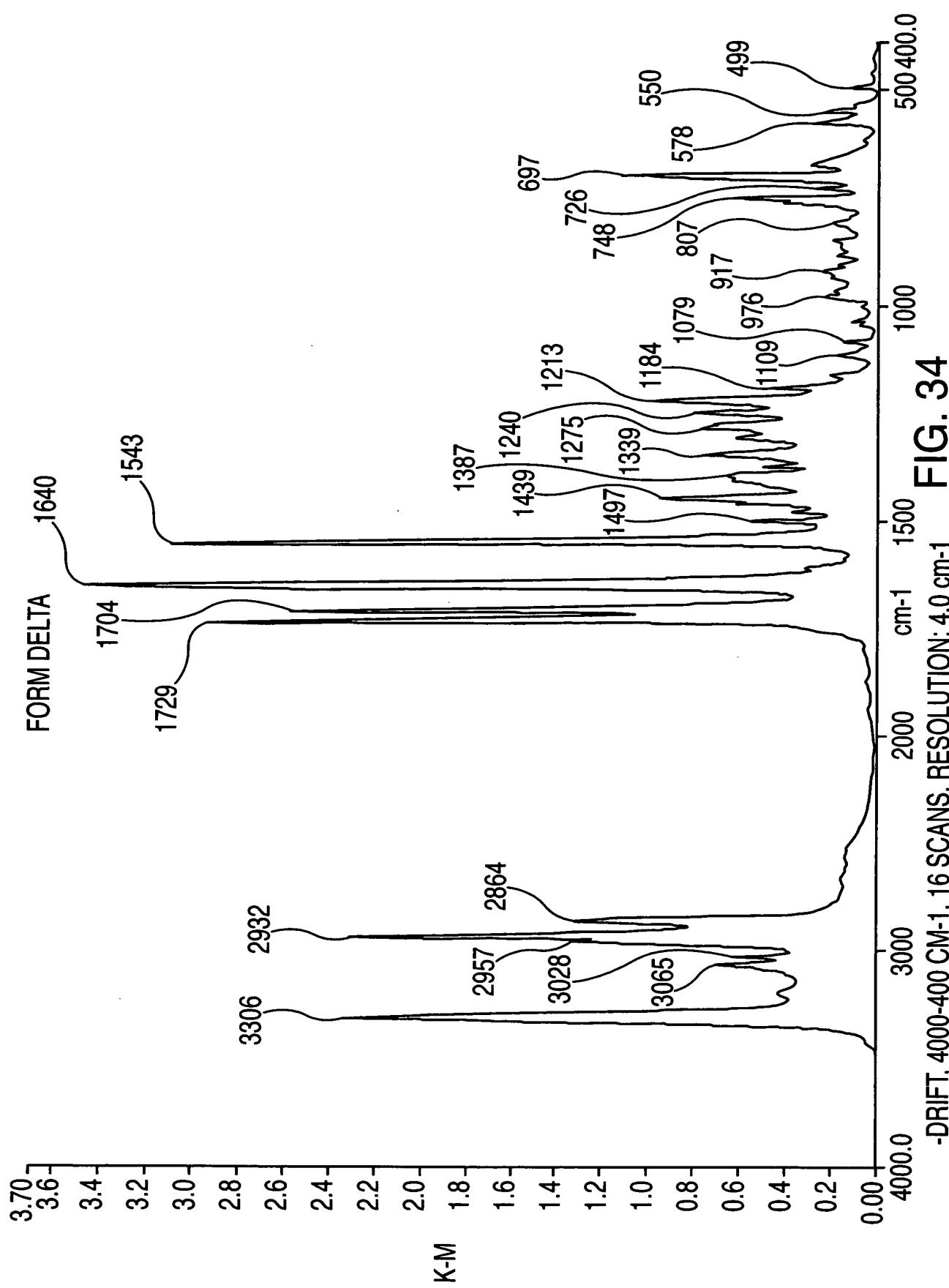
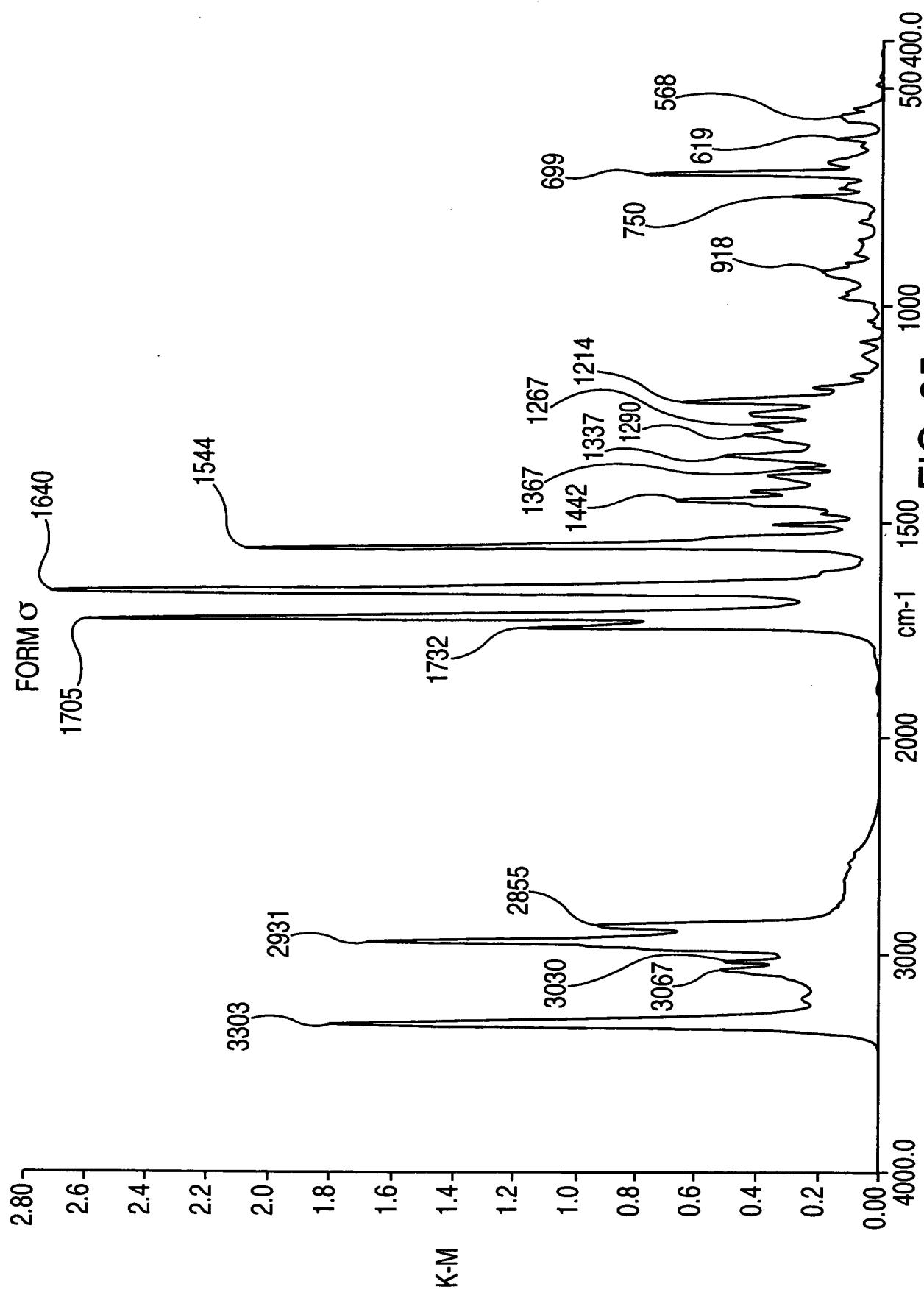
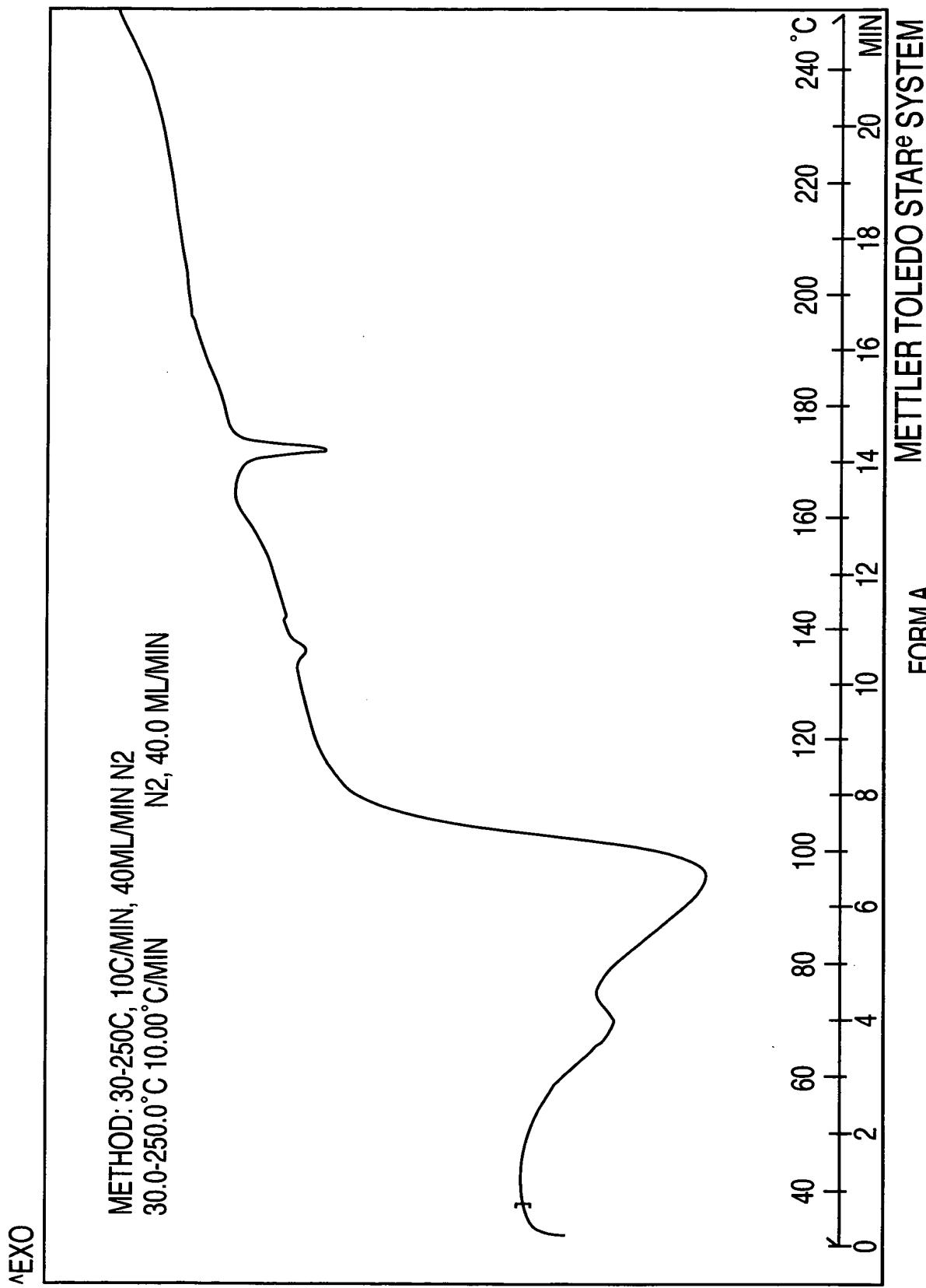


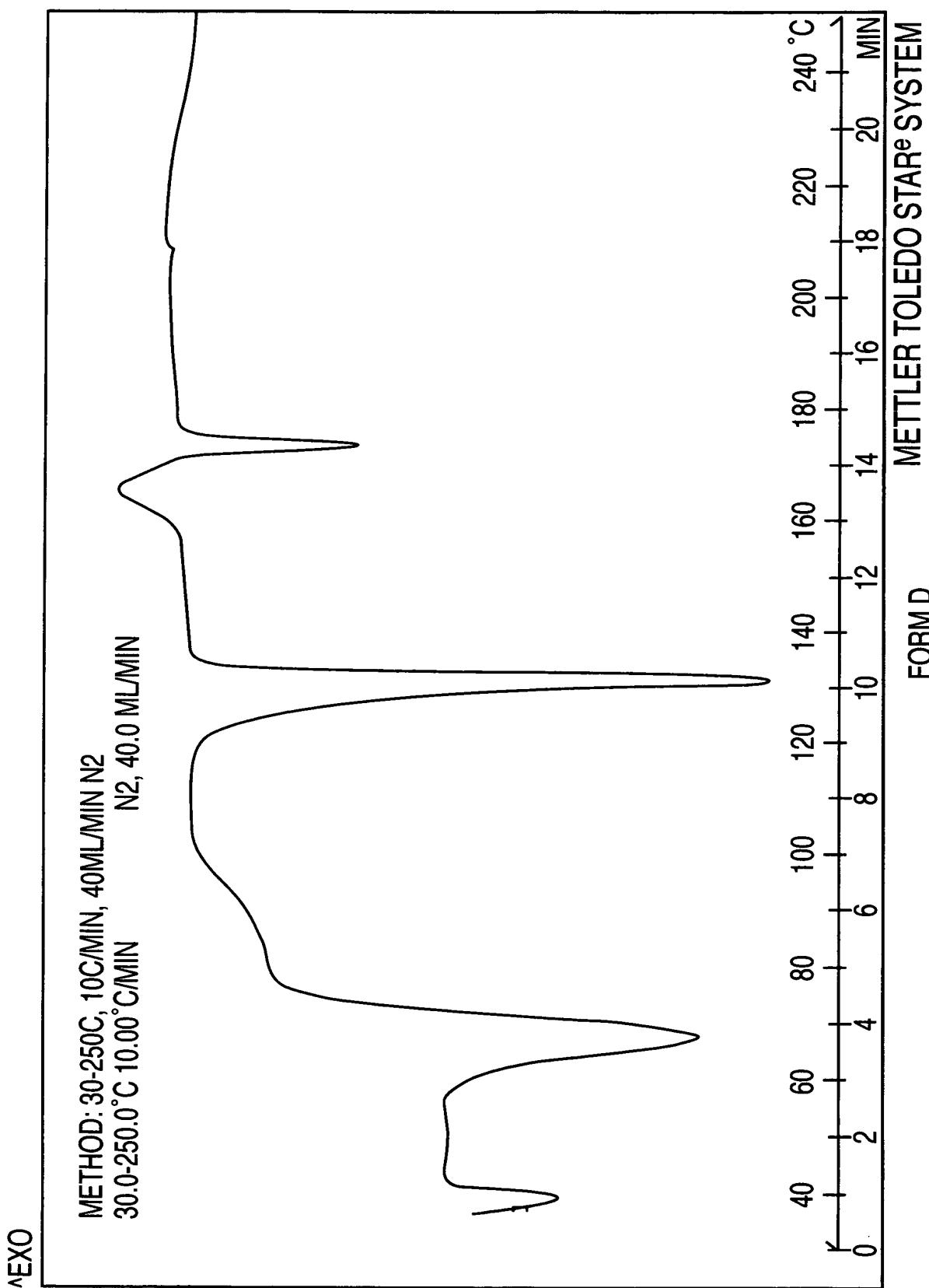
FIG. 33
-DRIFT, 4000-400 CM-1, 16 SCANS, RESOLUTION: 4.00 cm-1





-DRIFT, 4000-400 cm^{-1} , 16 SCANS, RESOLUTION: 4.0 cm^{-1} FIG. 35





FORM D
FIG. 37

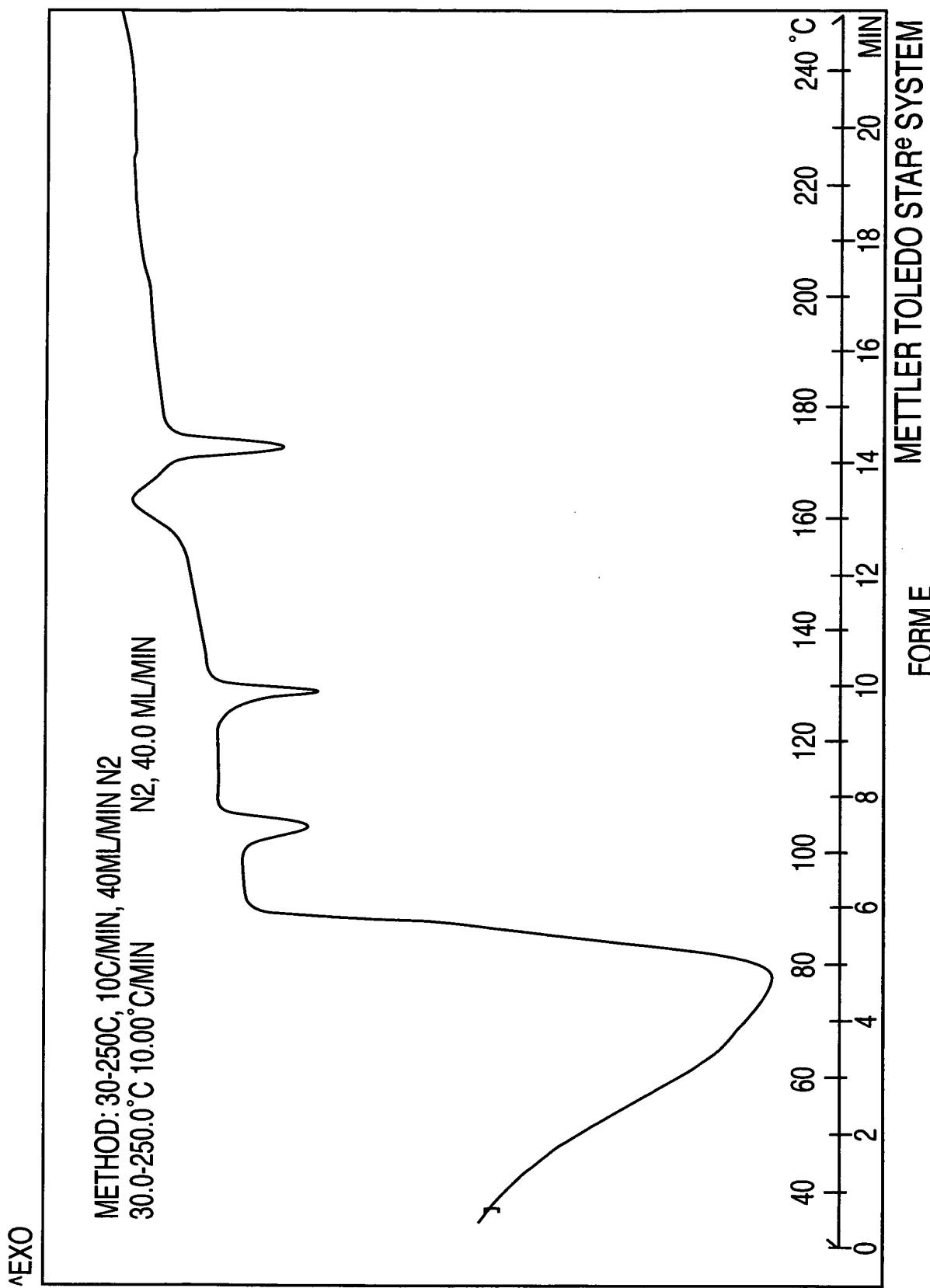


FIG. 38
FORM E

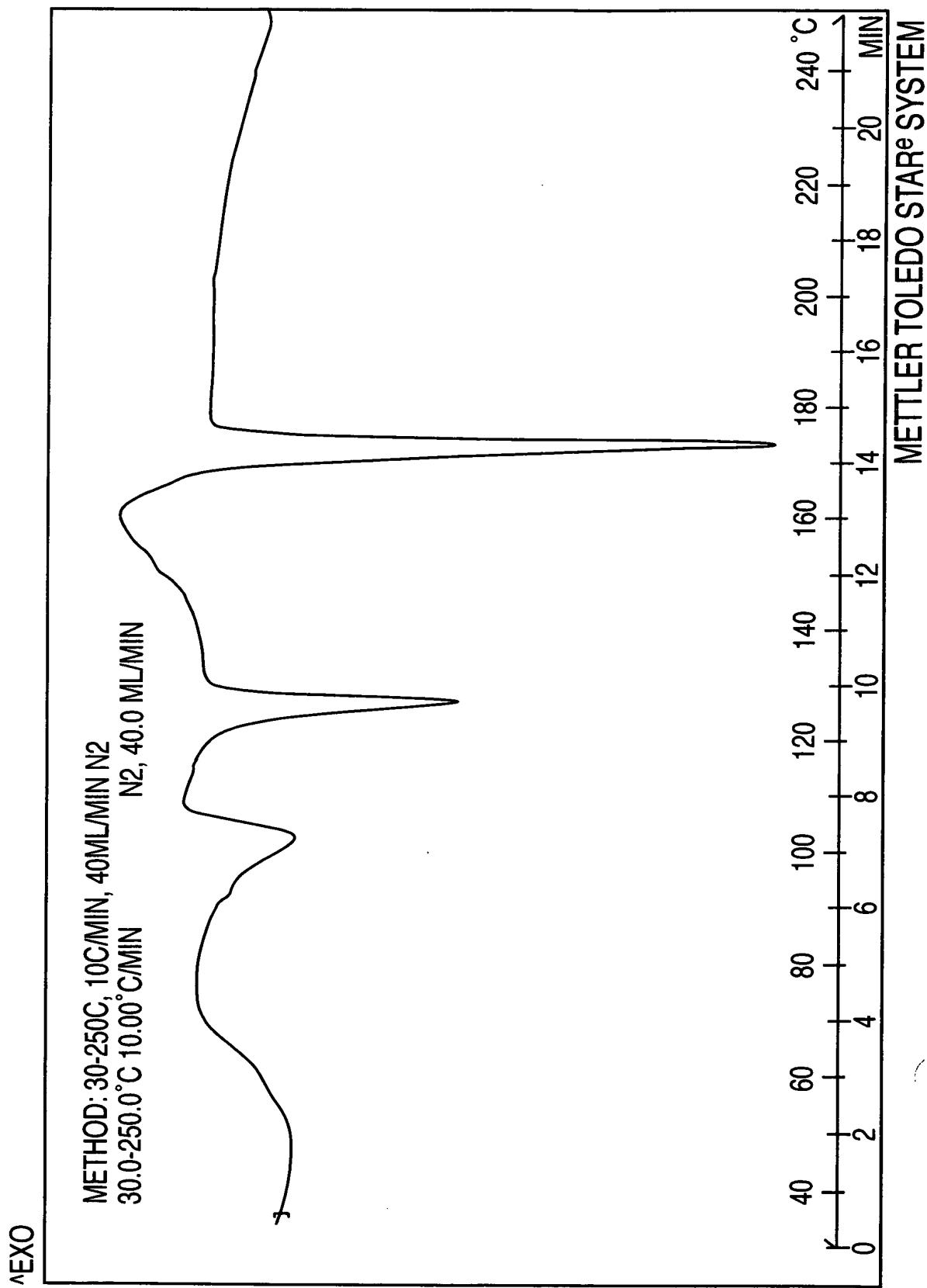
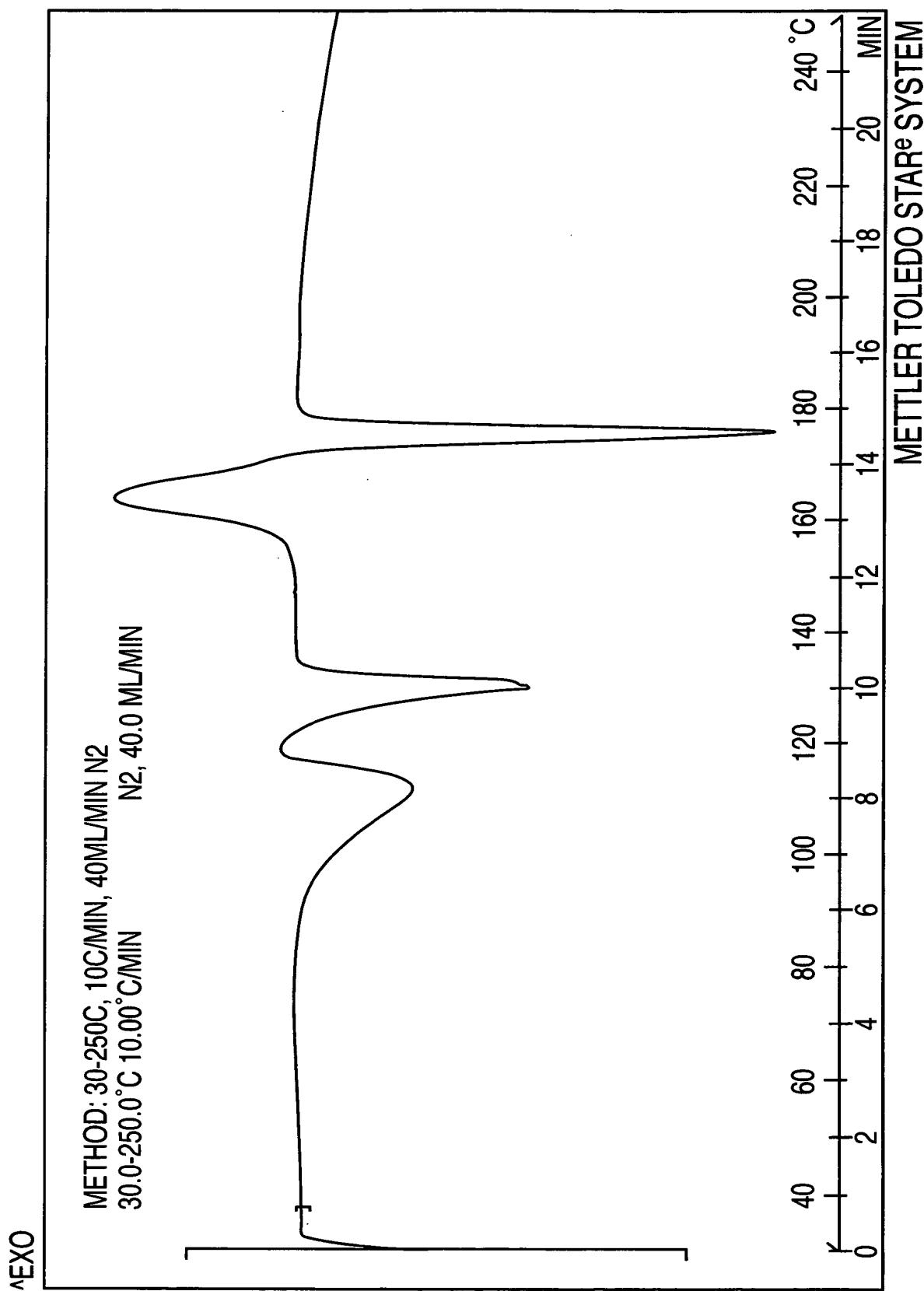


FIG. 39

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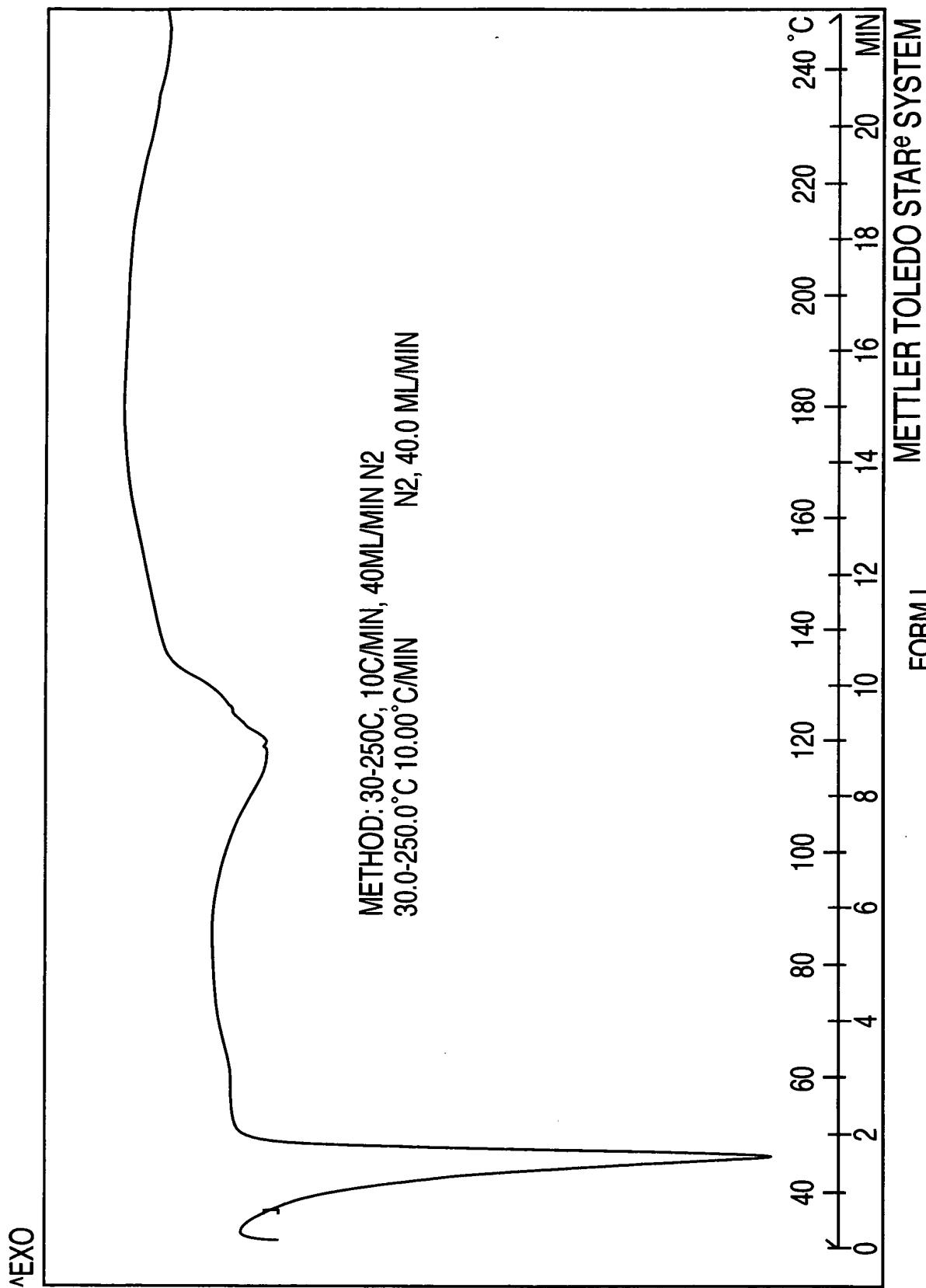
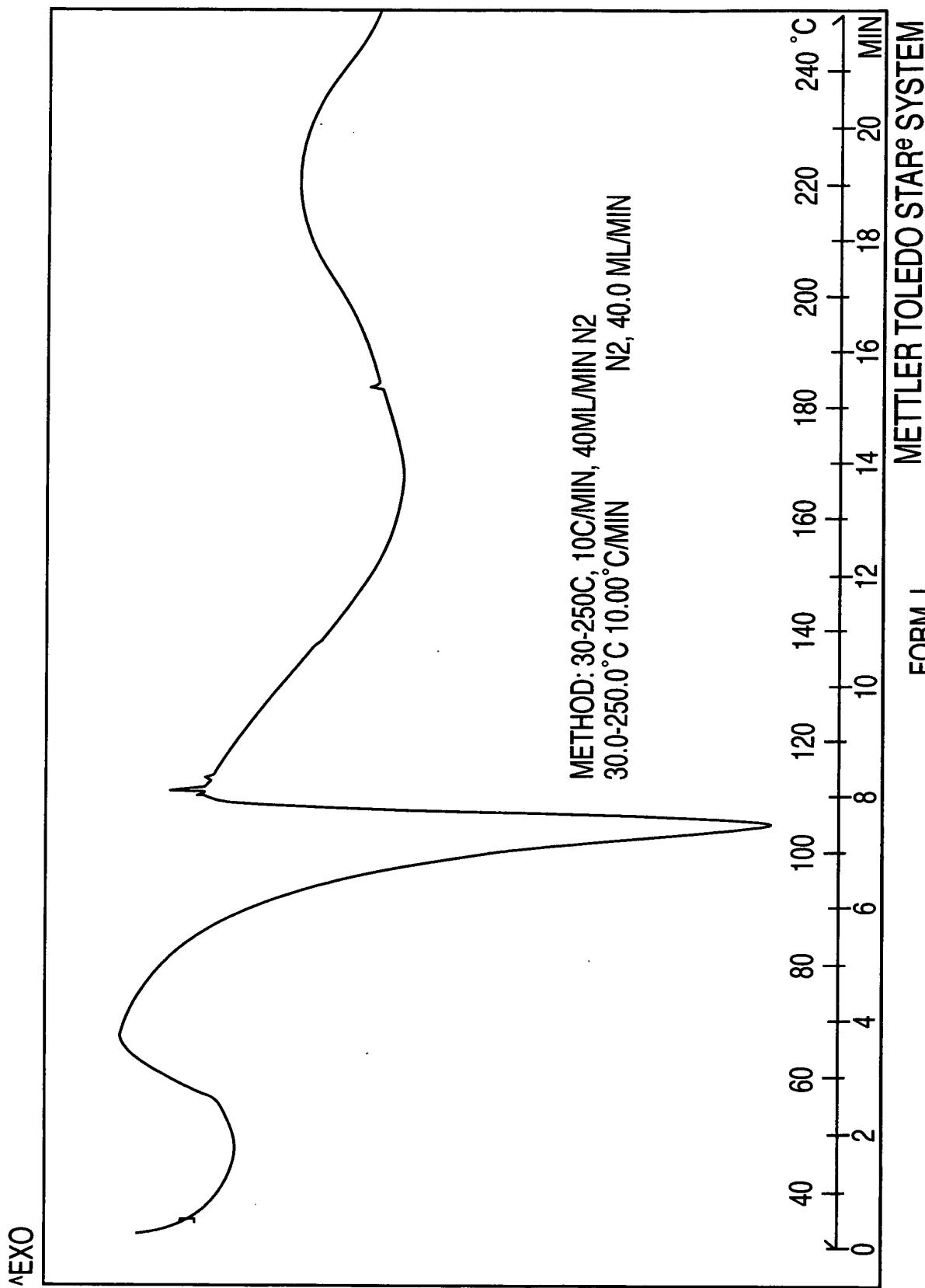
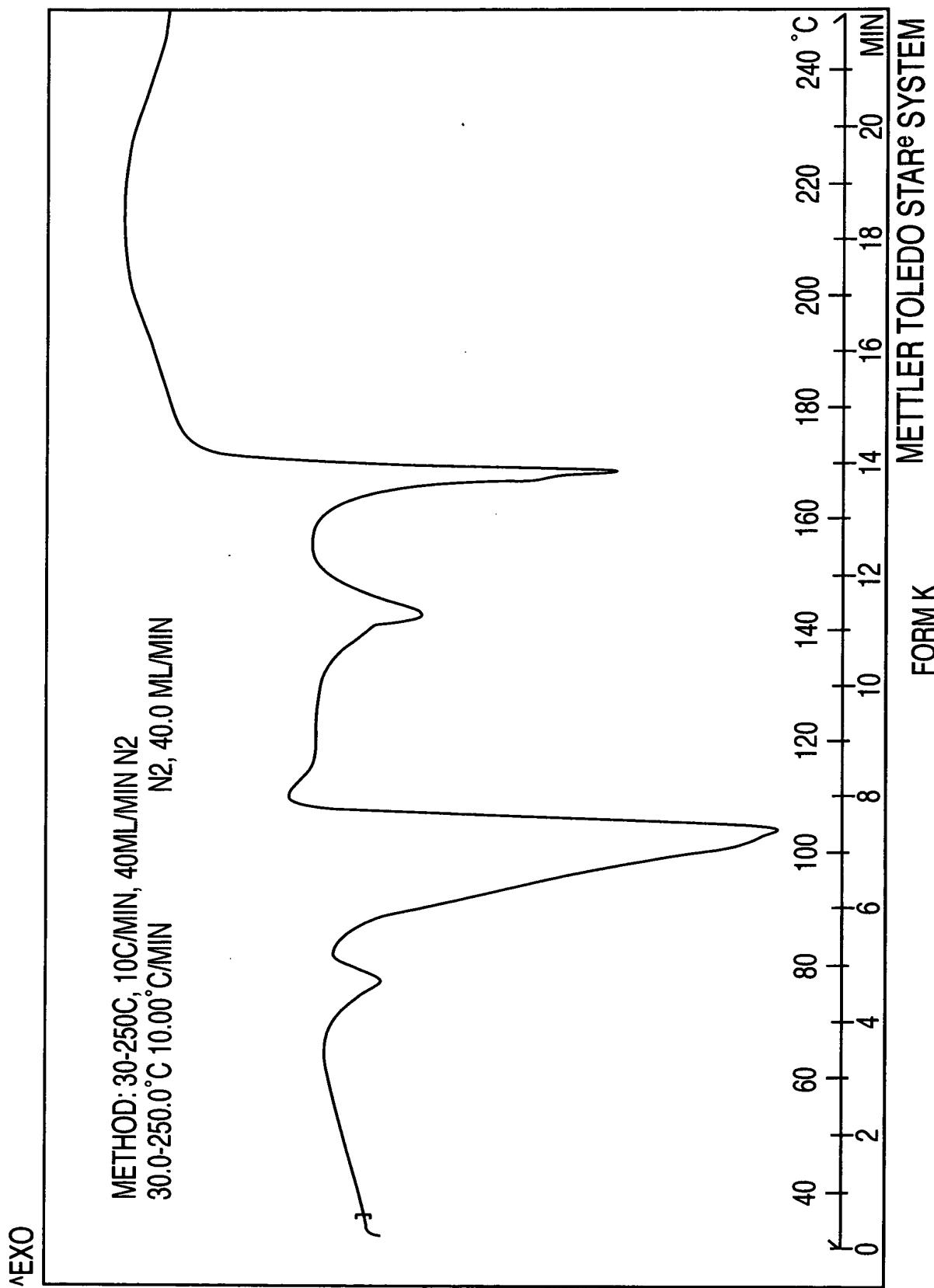
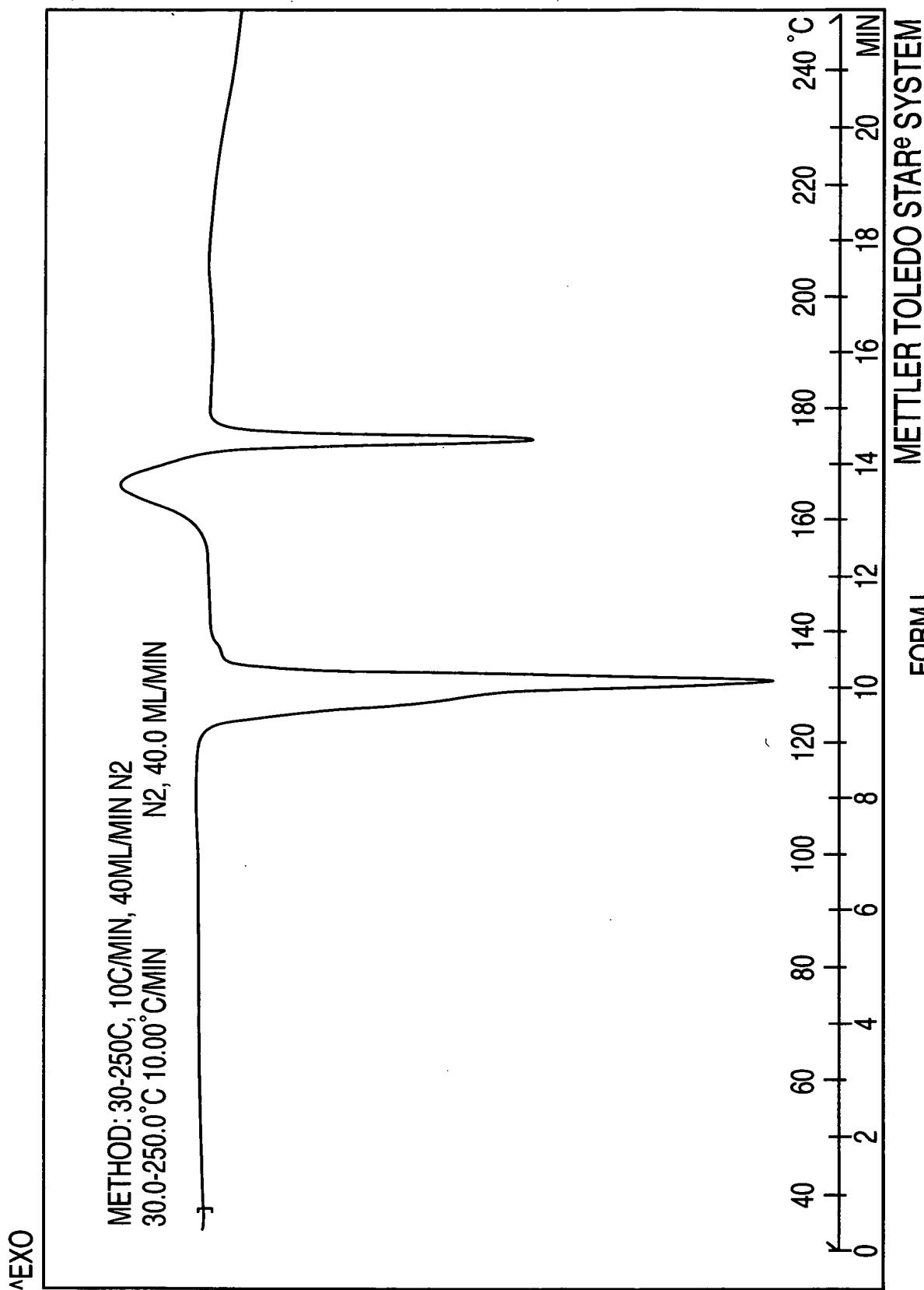


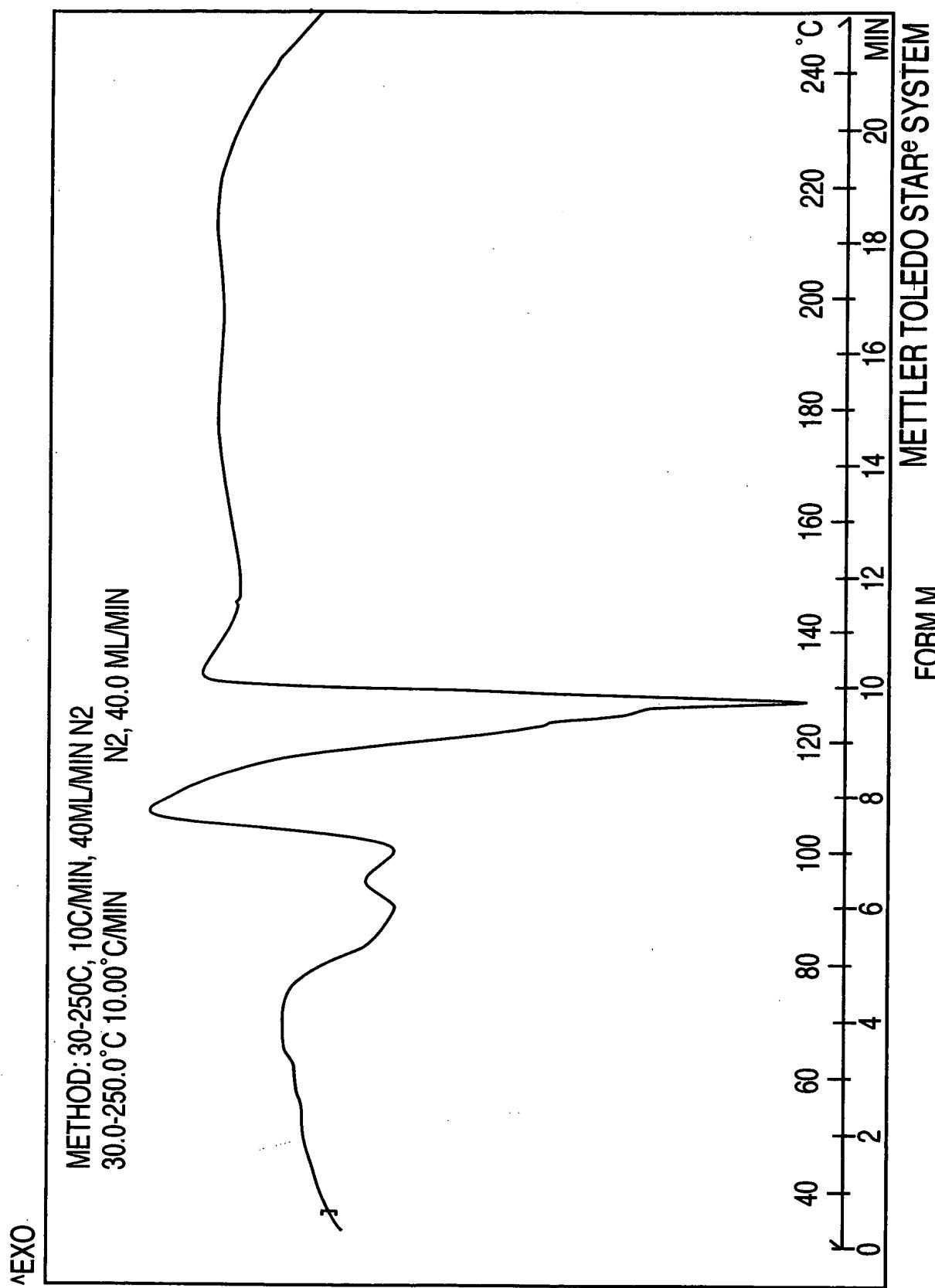
FIG. 41

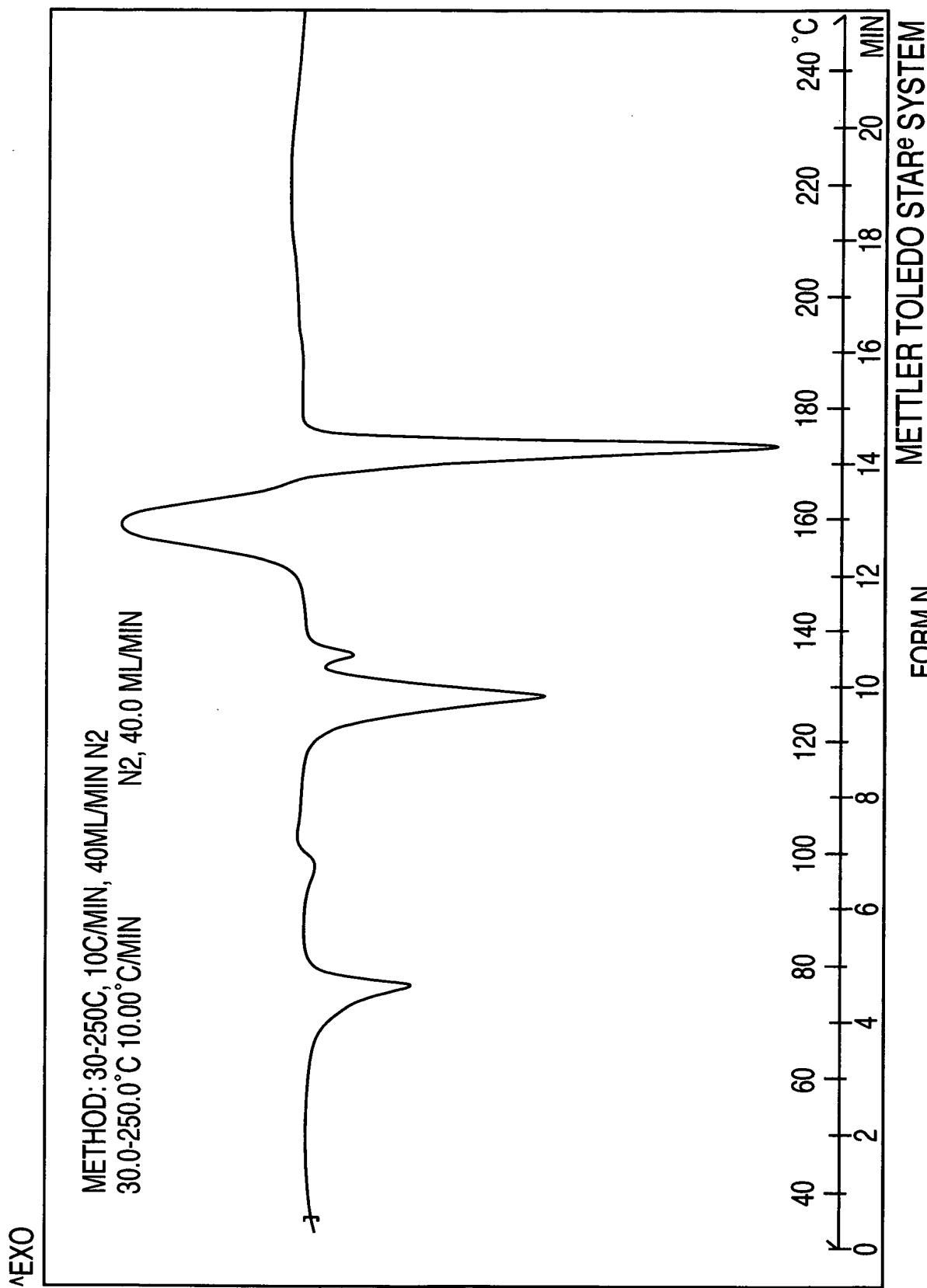




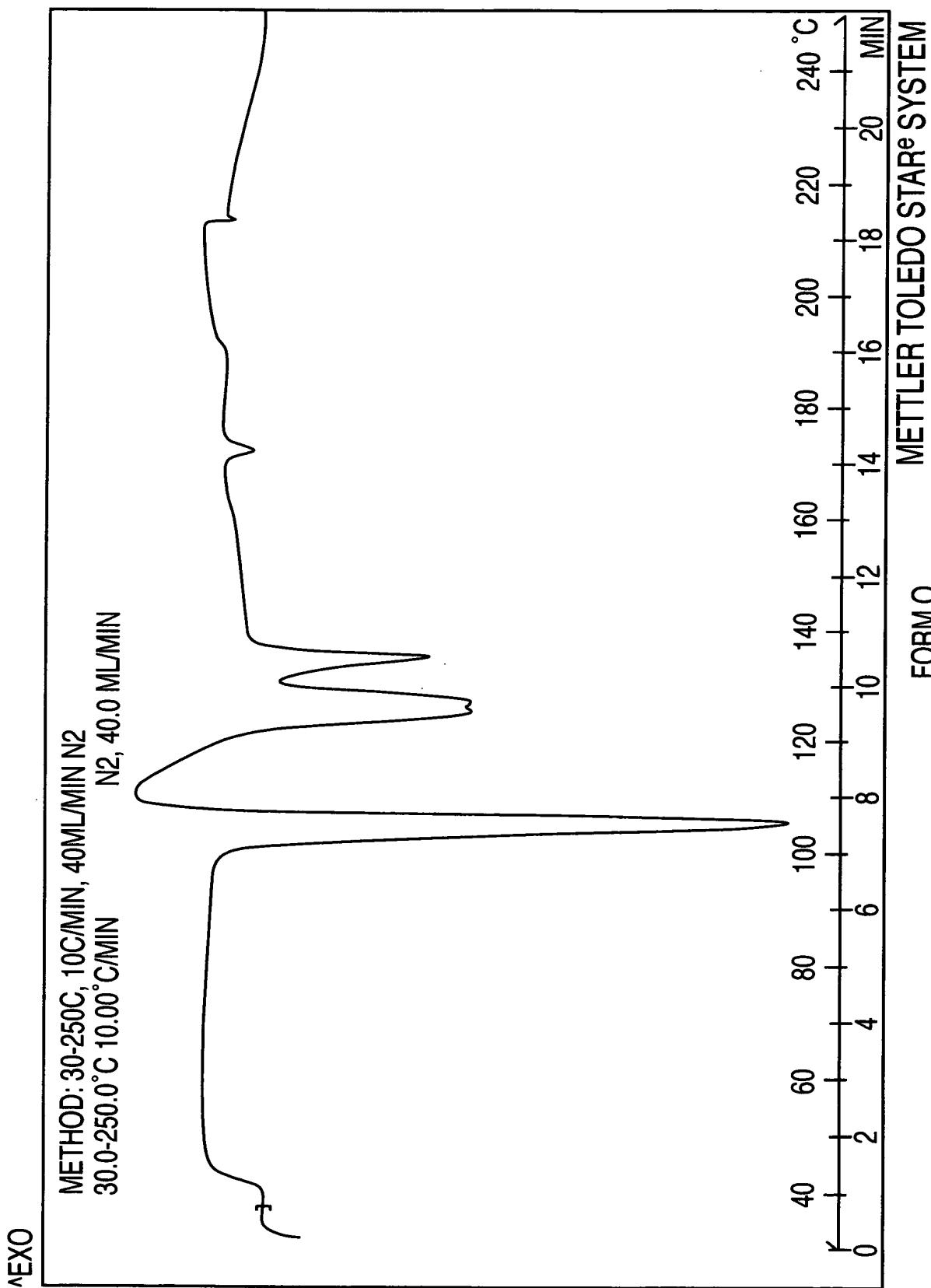
FORM K
FIG. 43







FORM N
FIG. 46



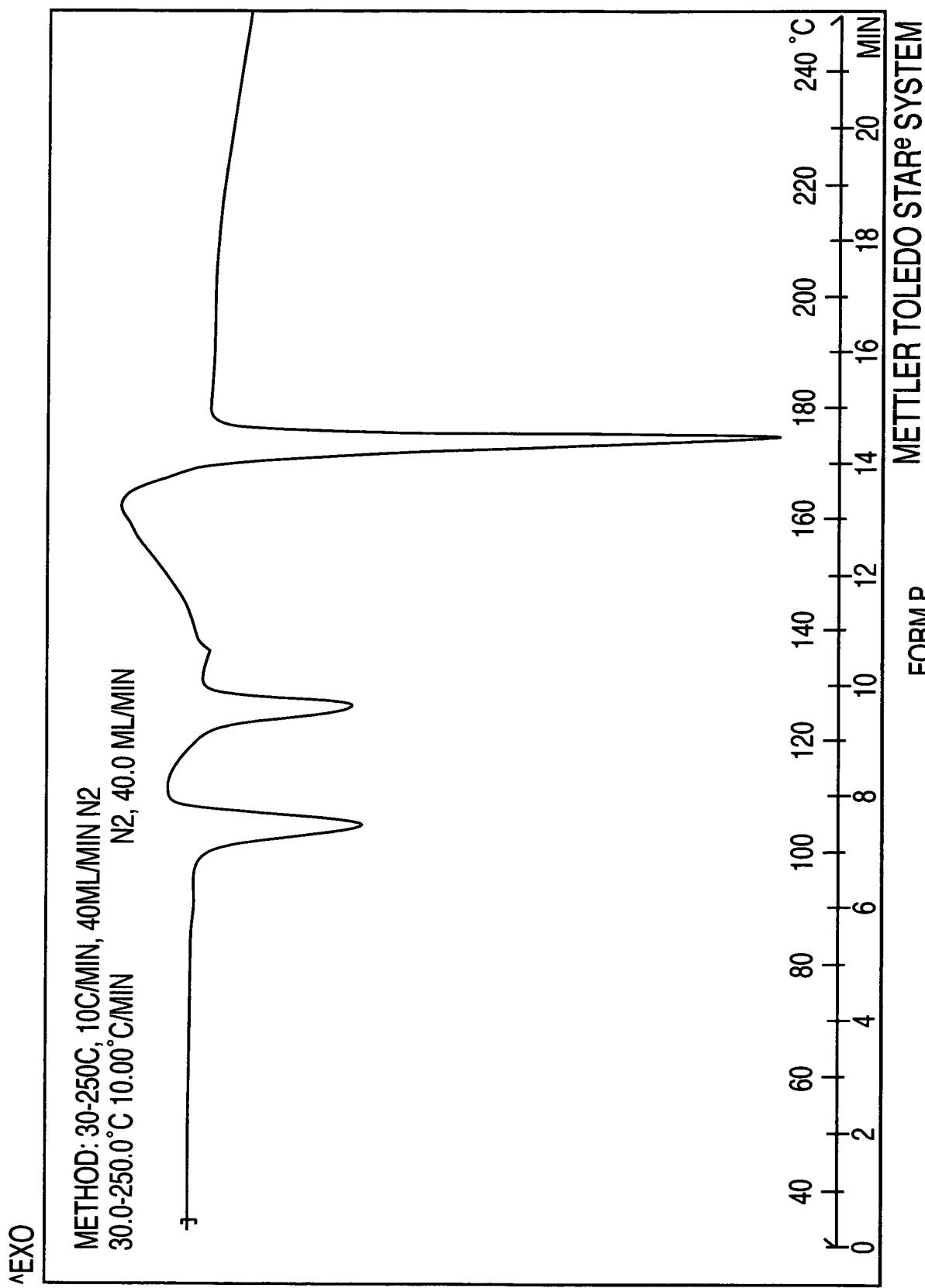


FIG. 48

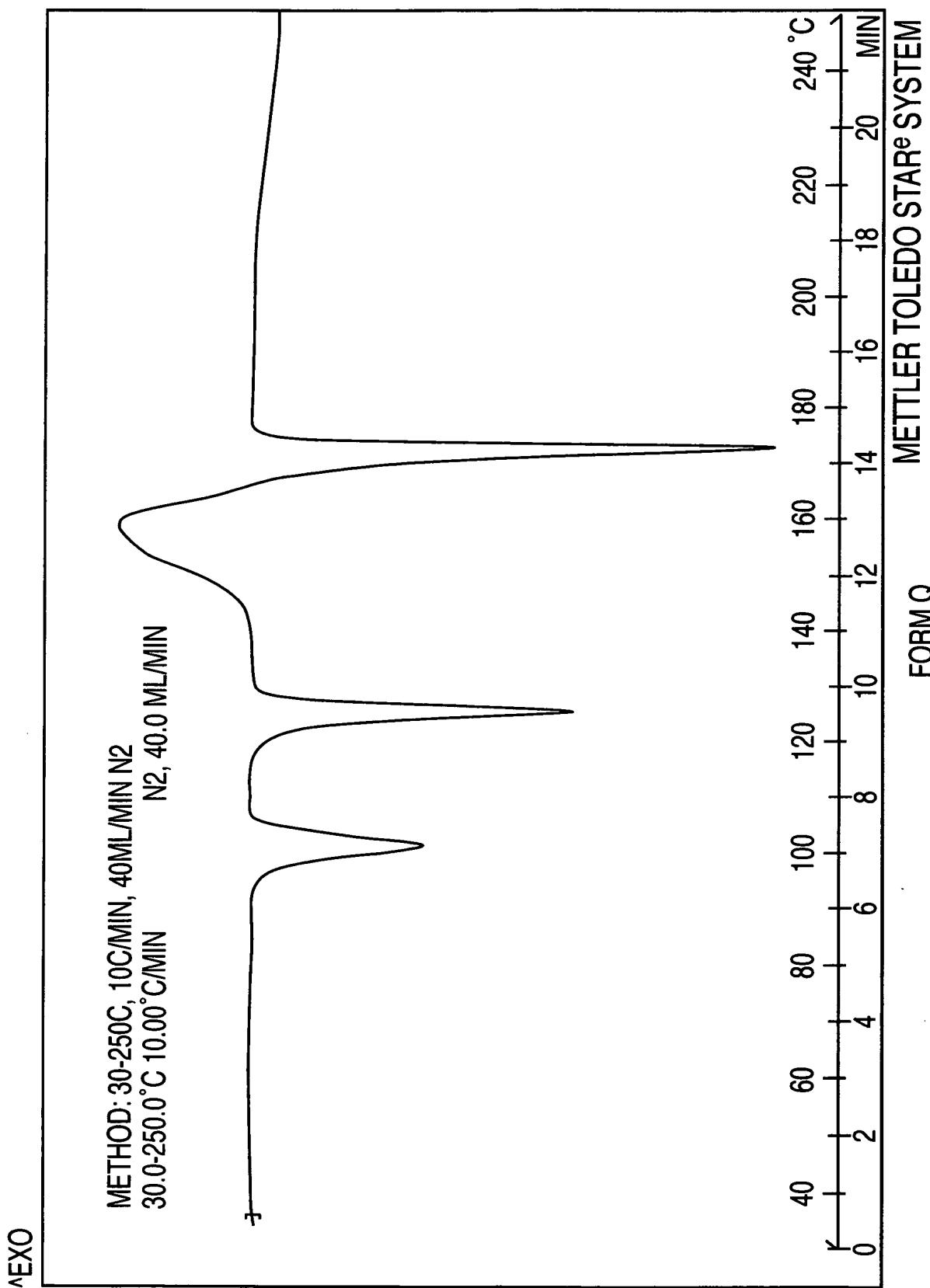
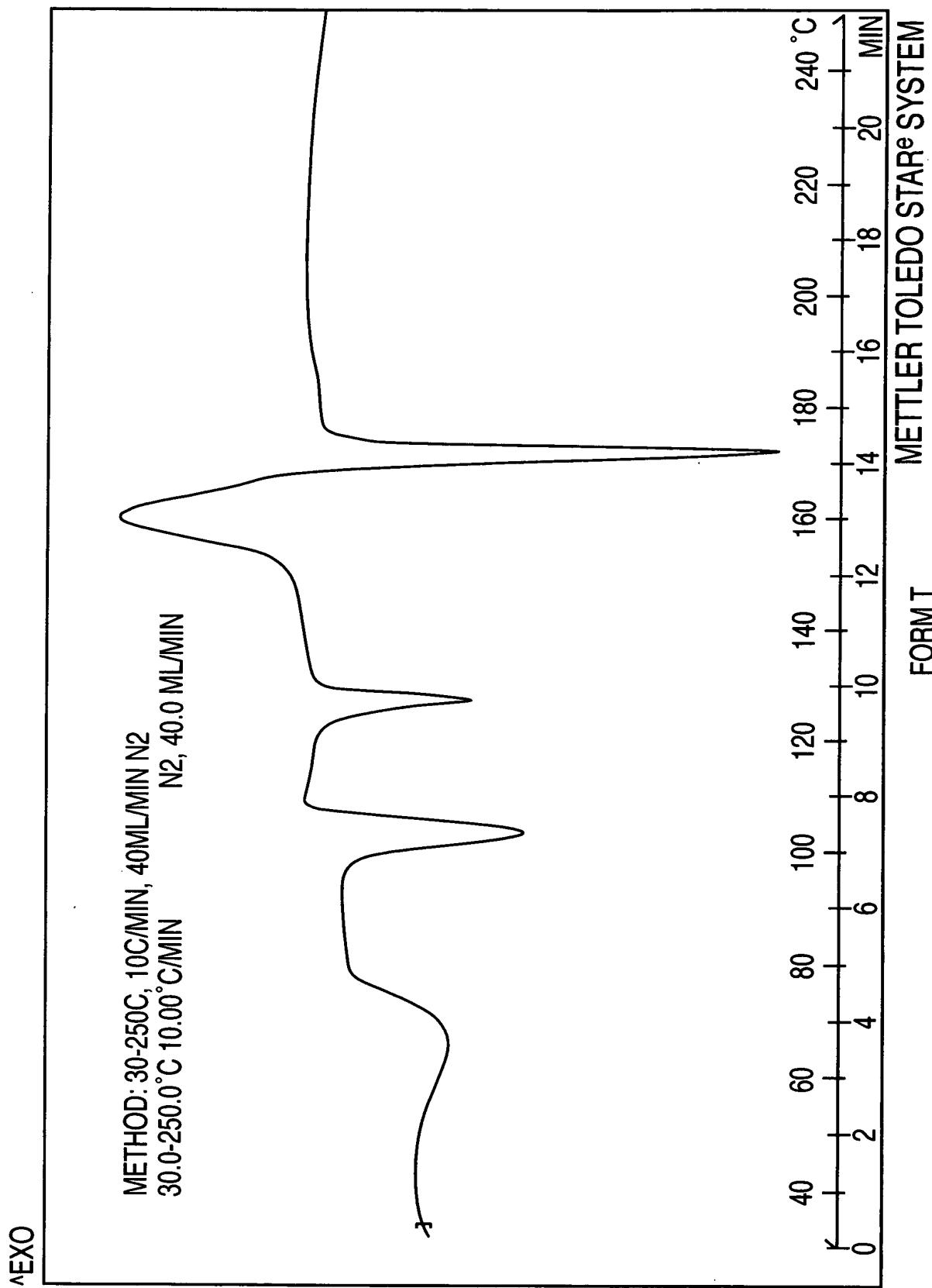
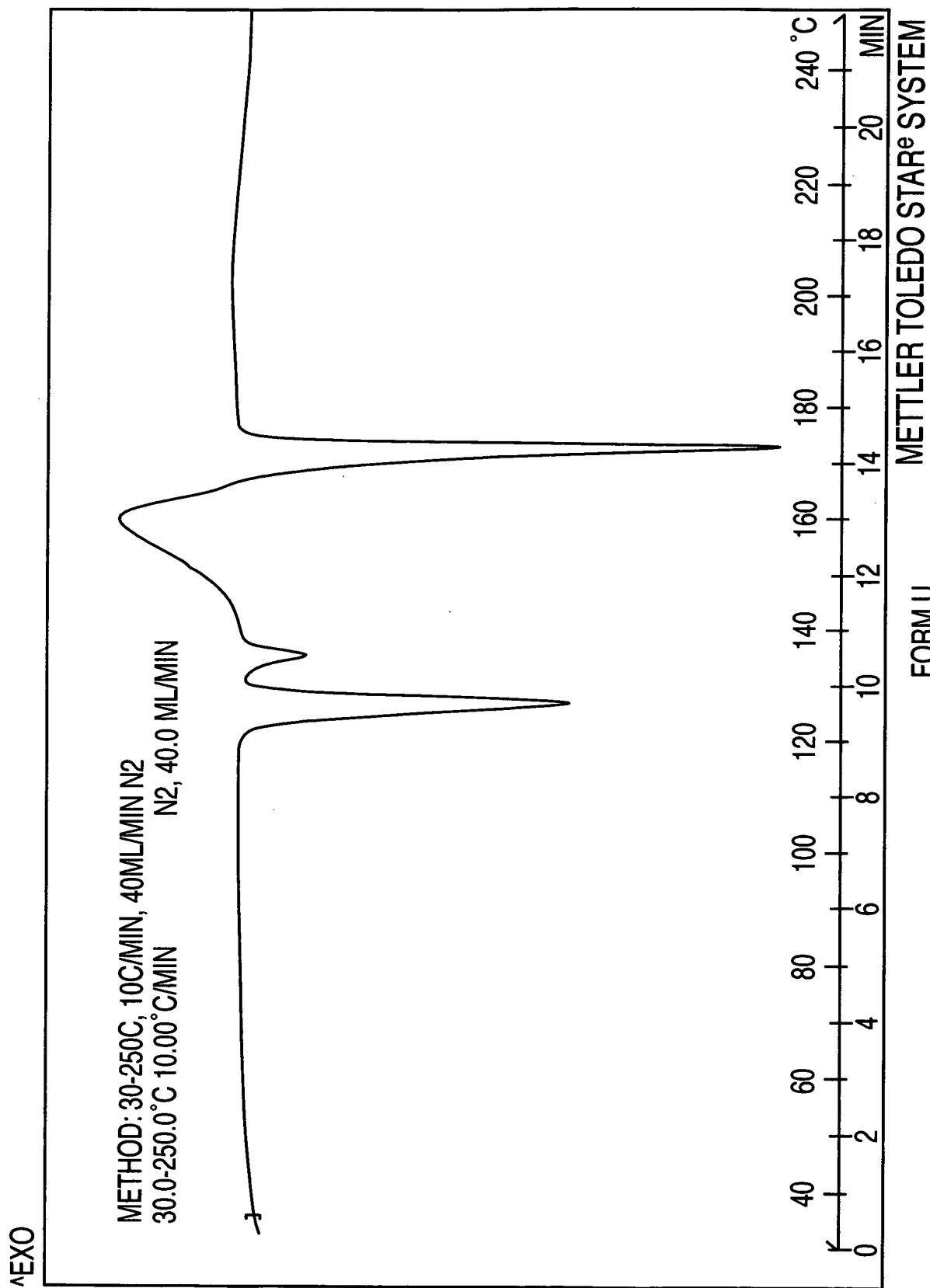
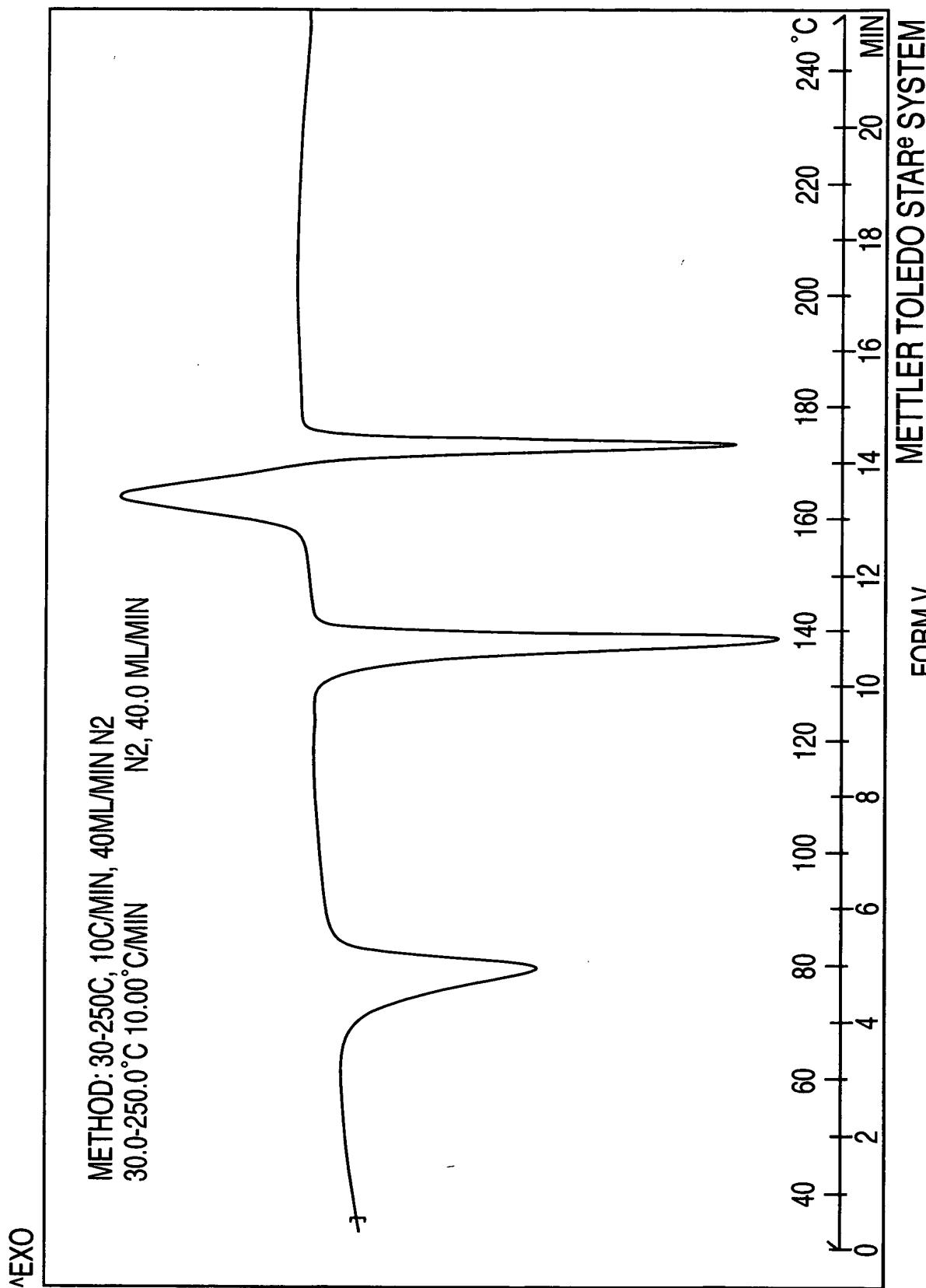
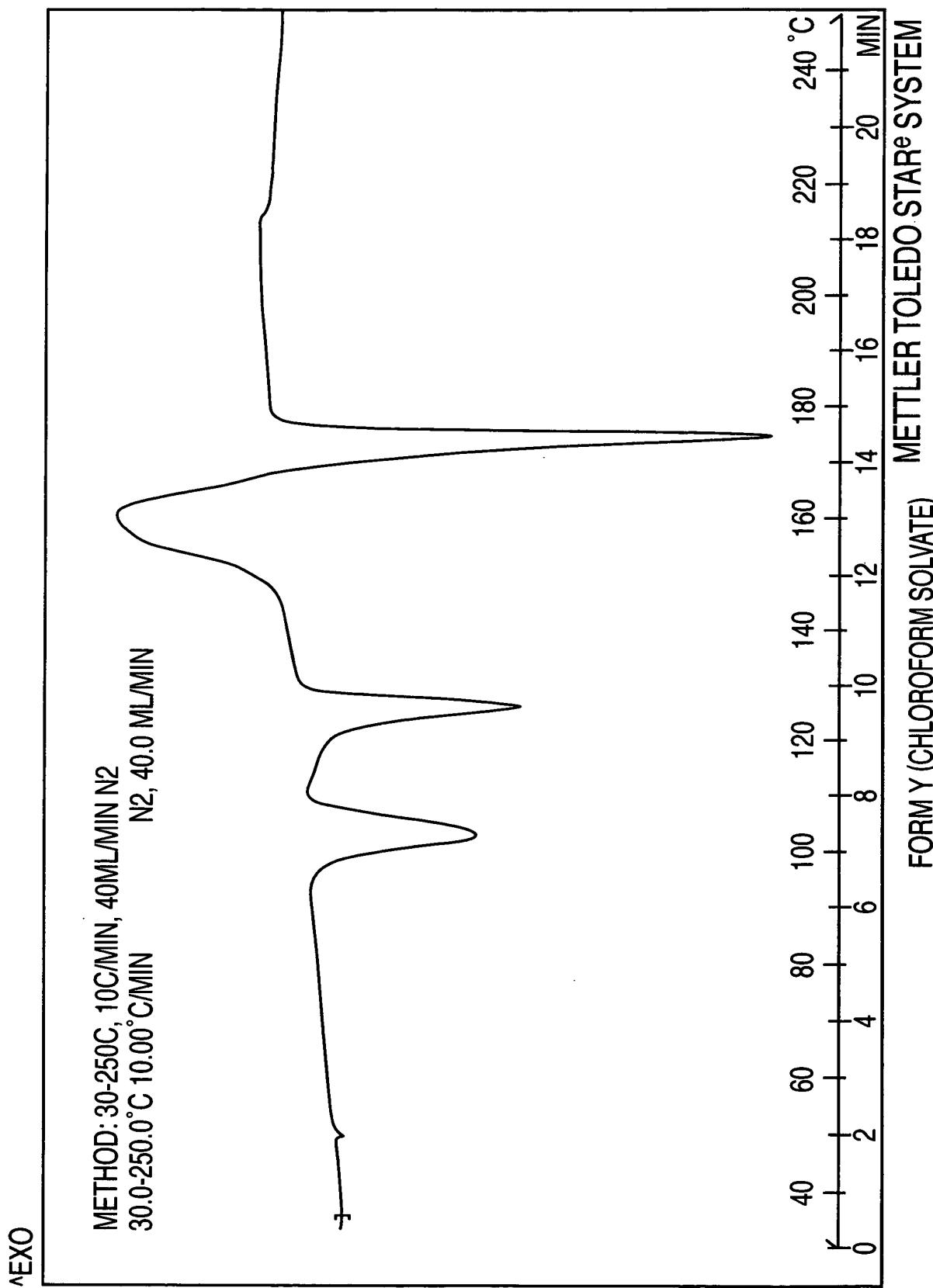


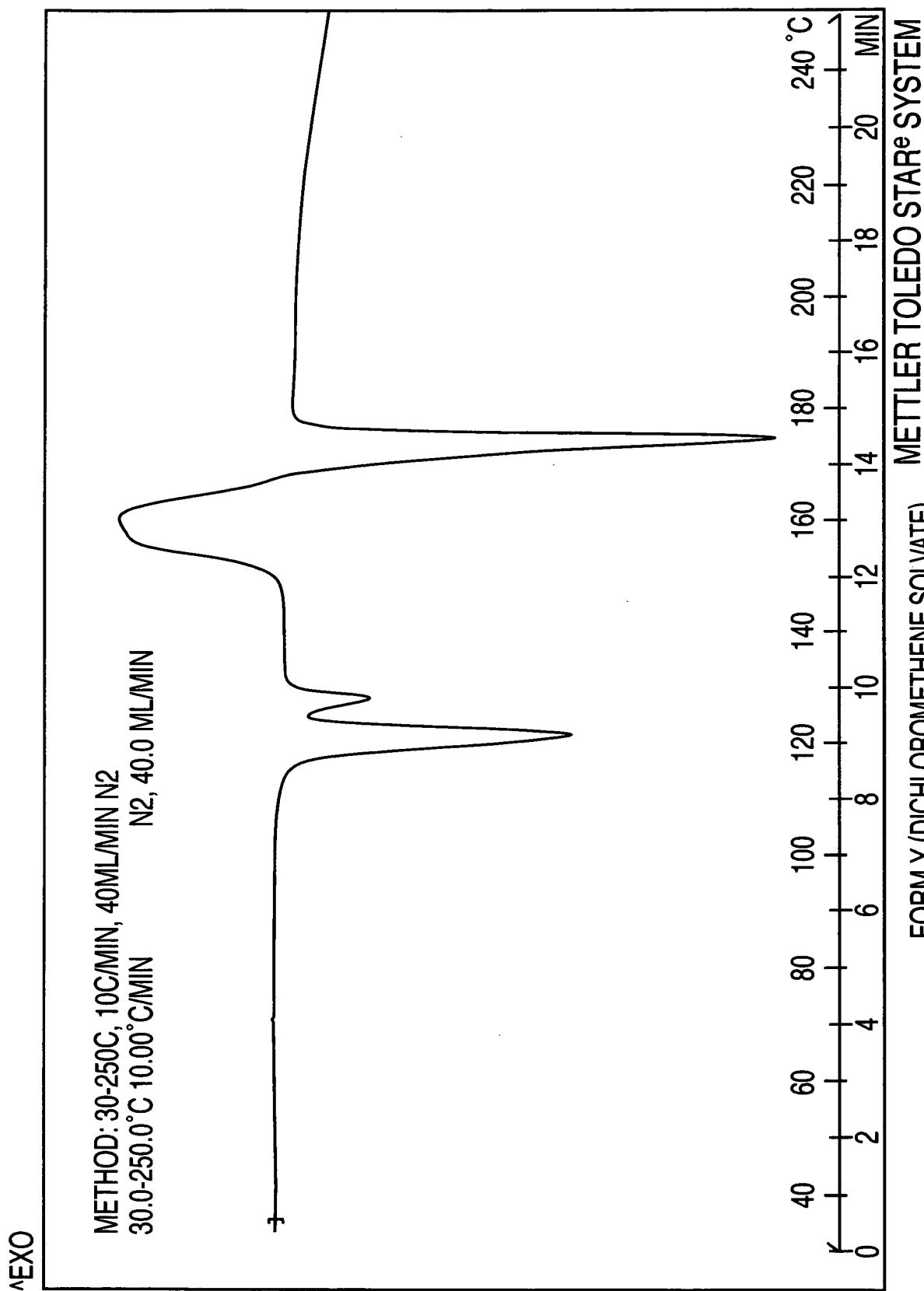
FIG. 49
FORM Q

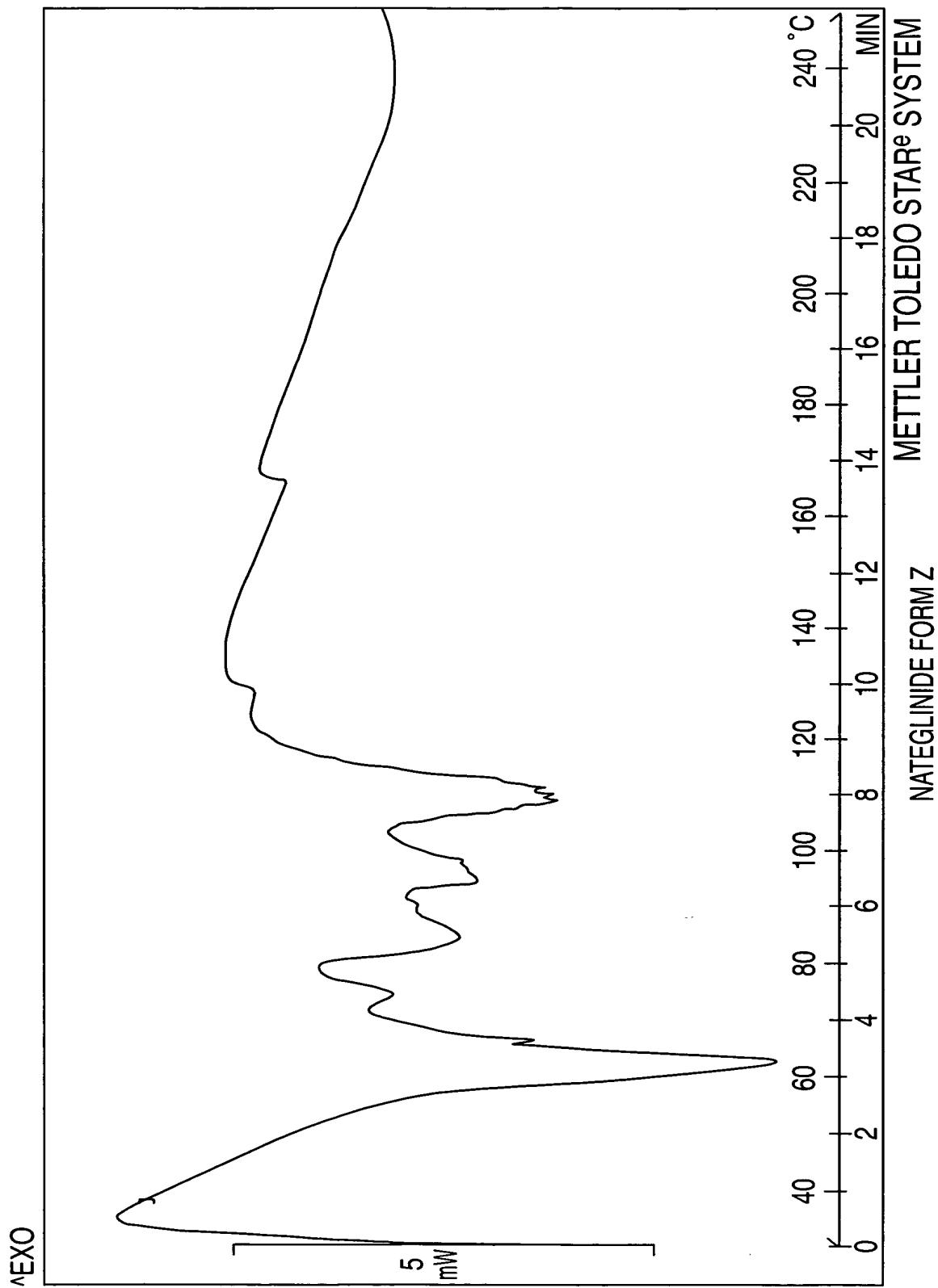


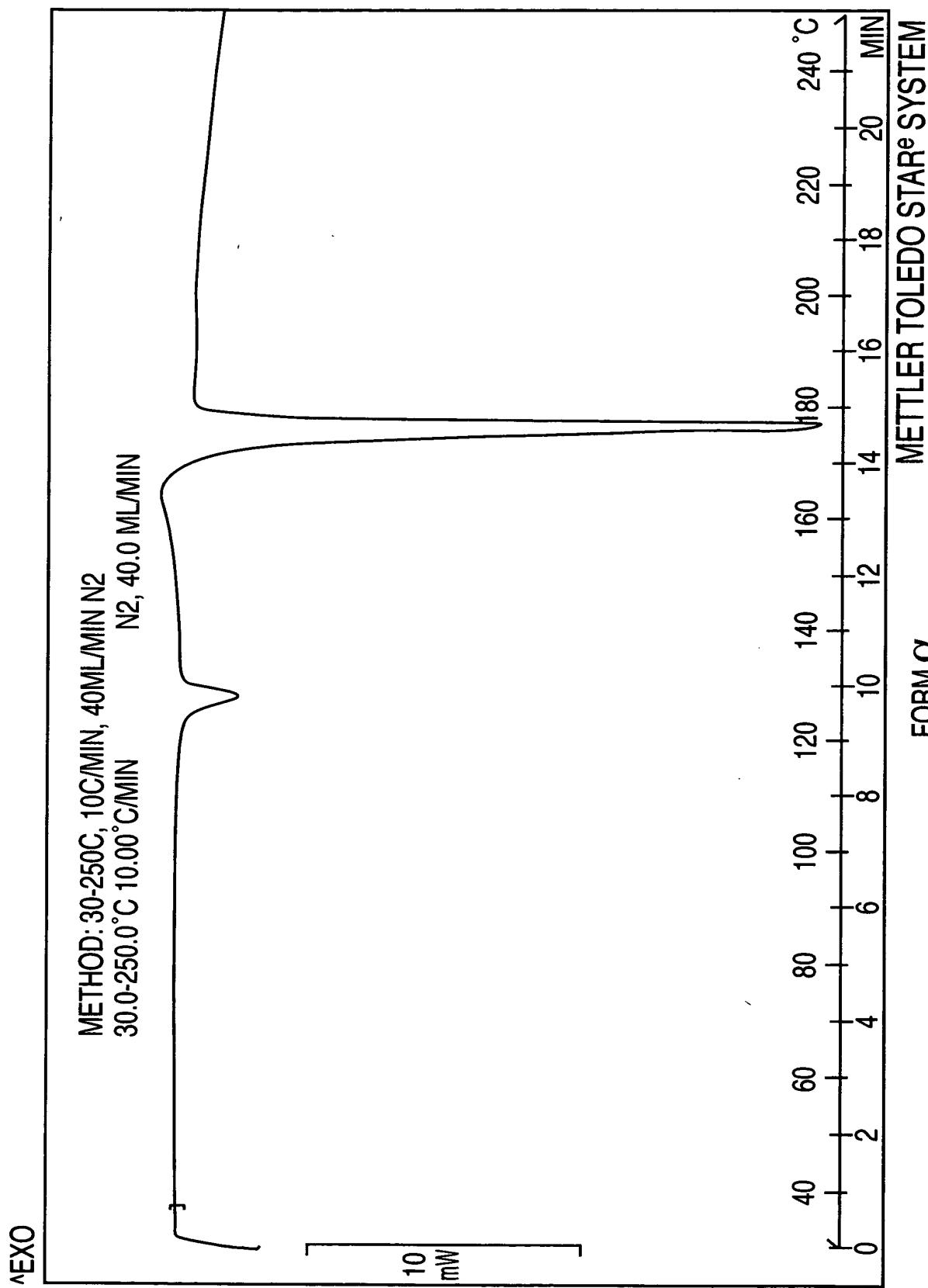




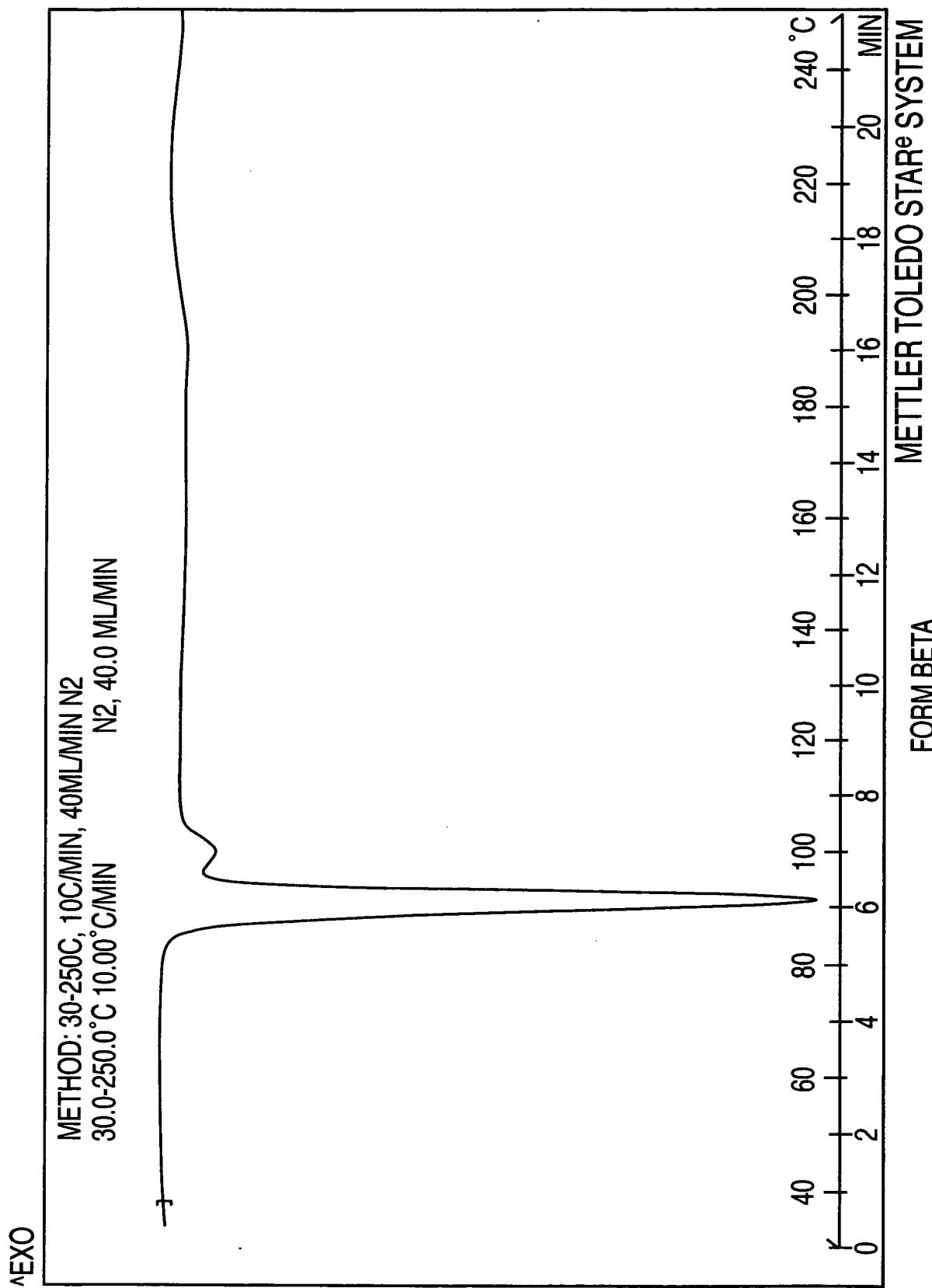


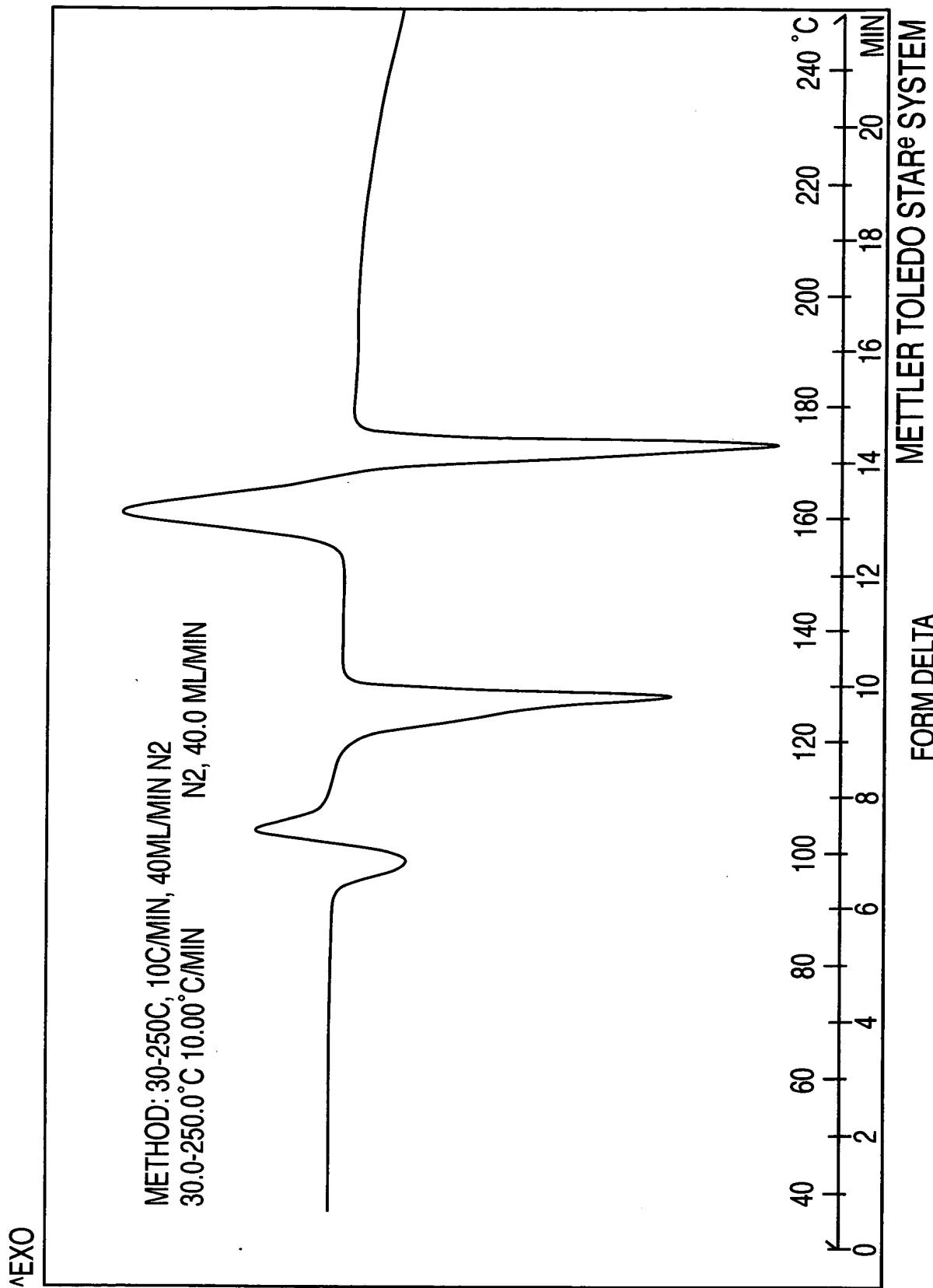




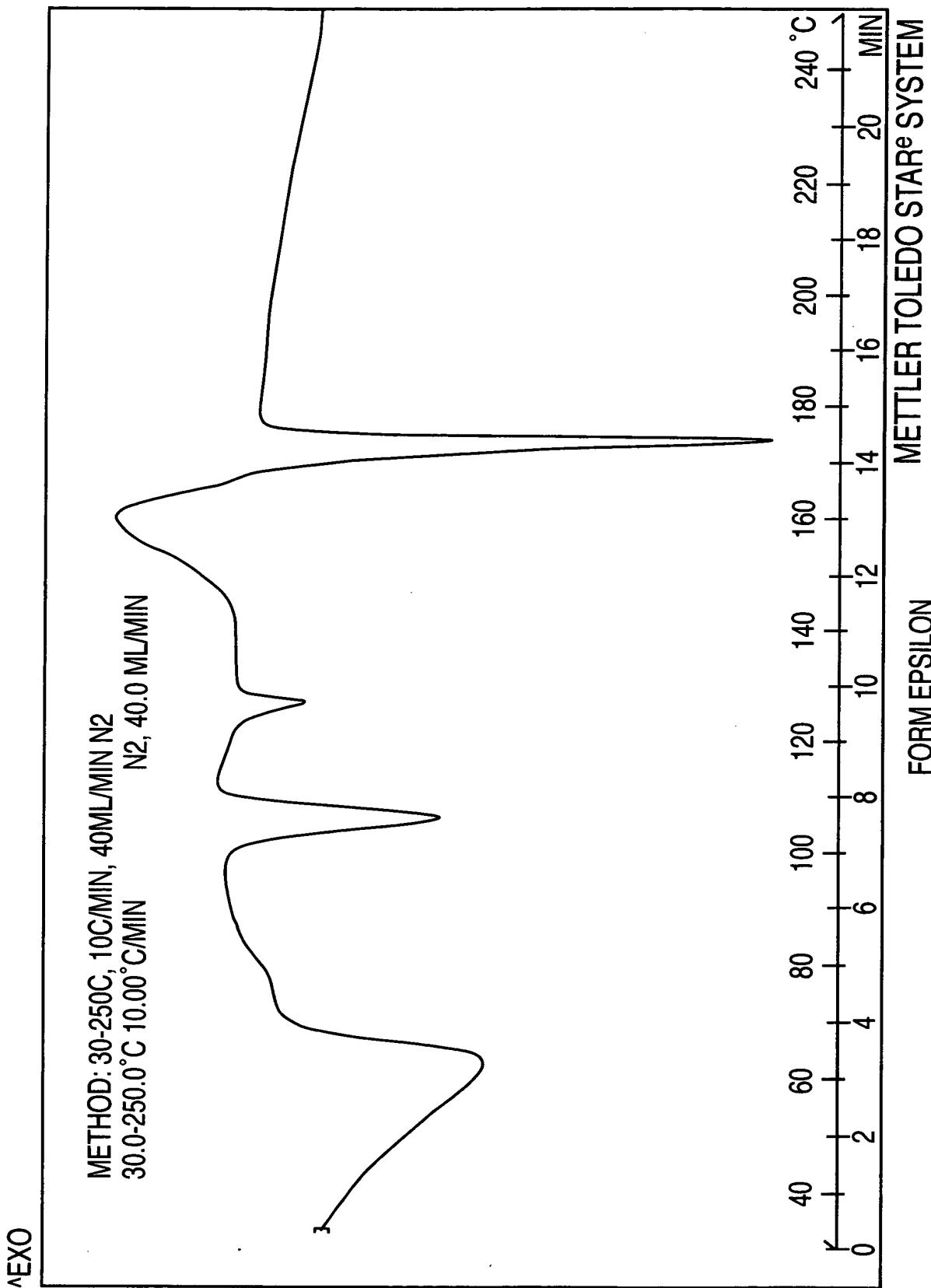


FORM α
FIG. 56



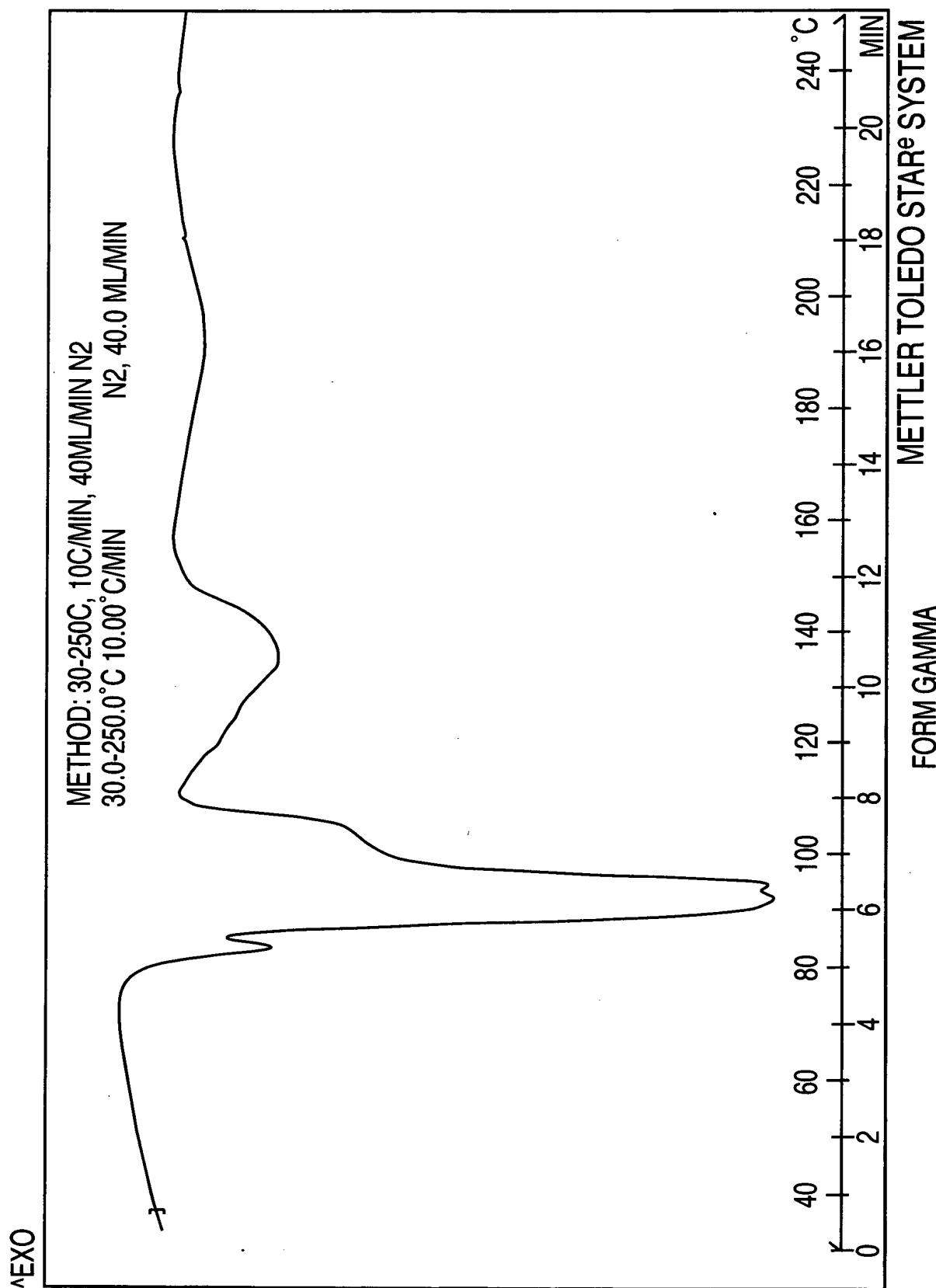


FORM DELTA
FIG. 58

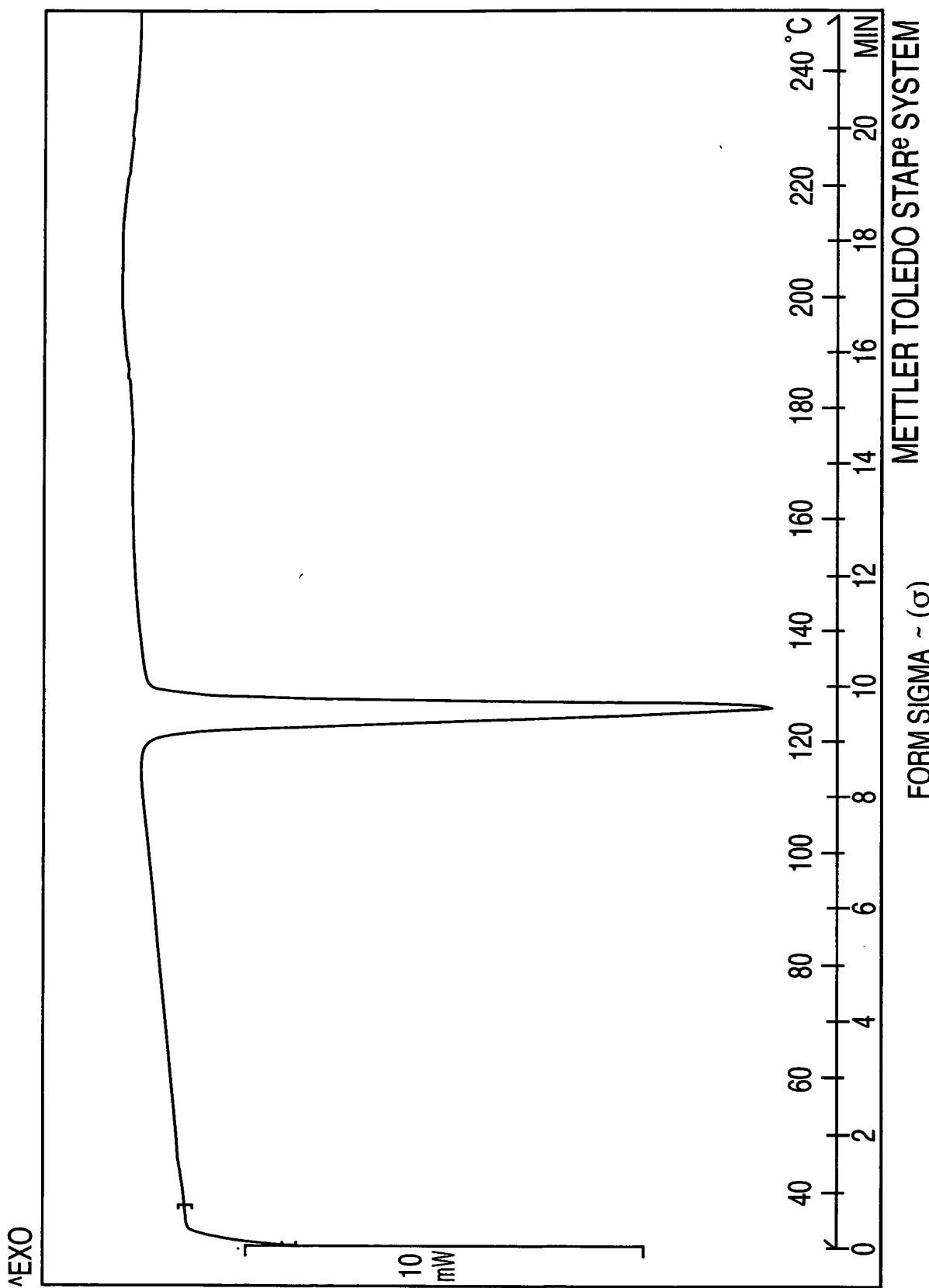


FORM EPSILON
FIG. 59

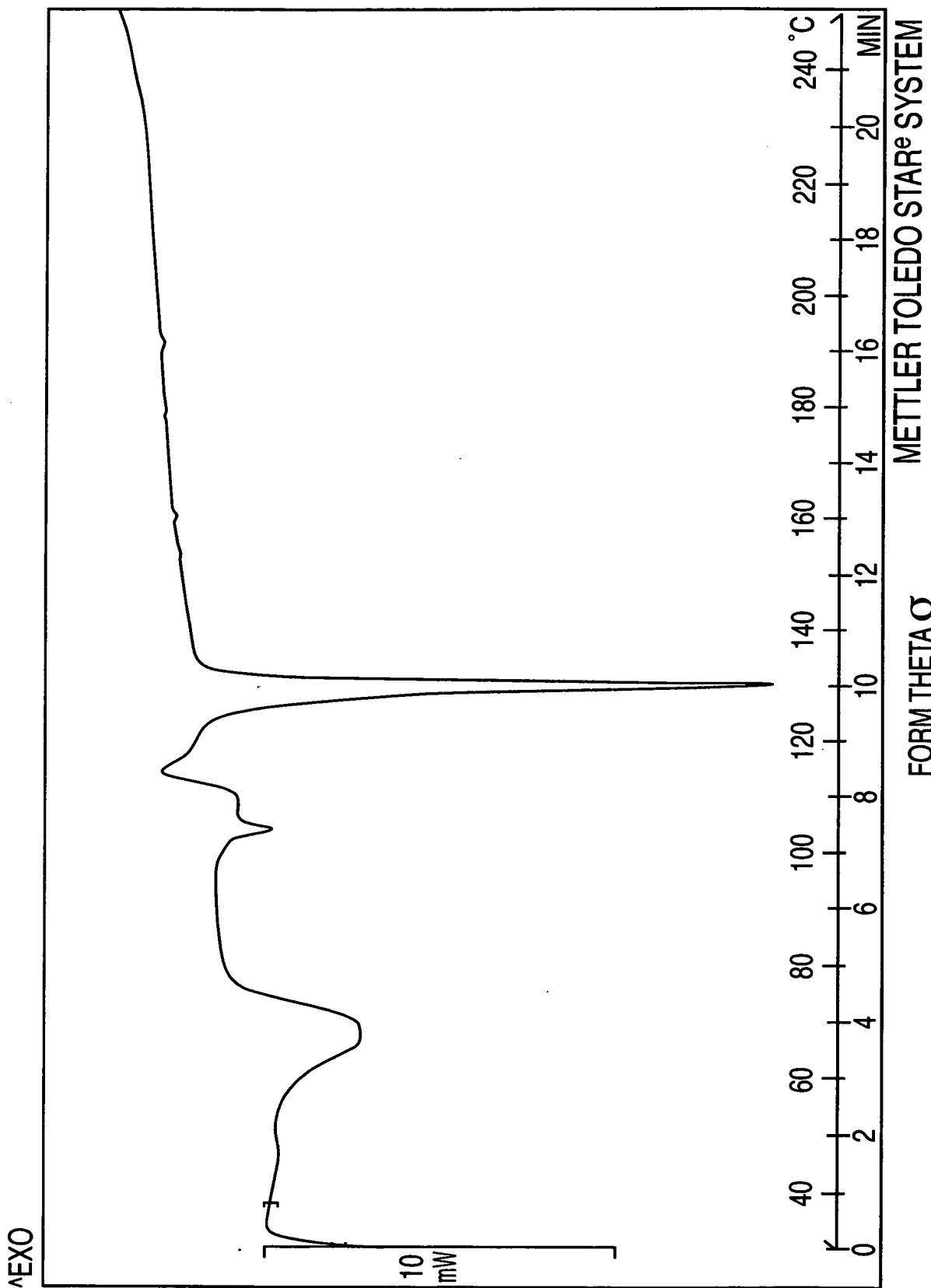
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FORM GAMMA
FIG. 60



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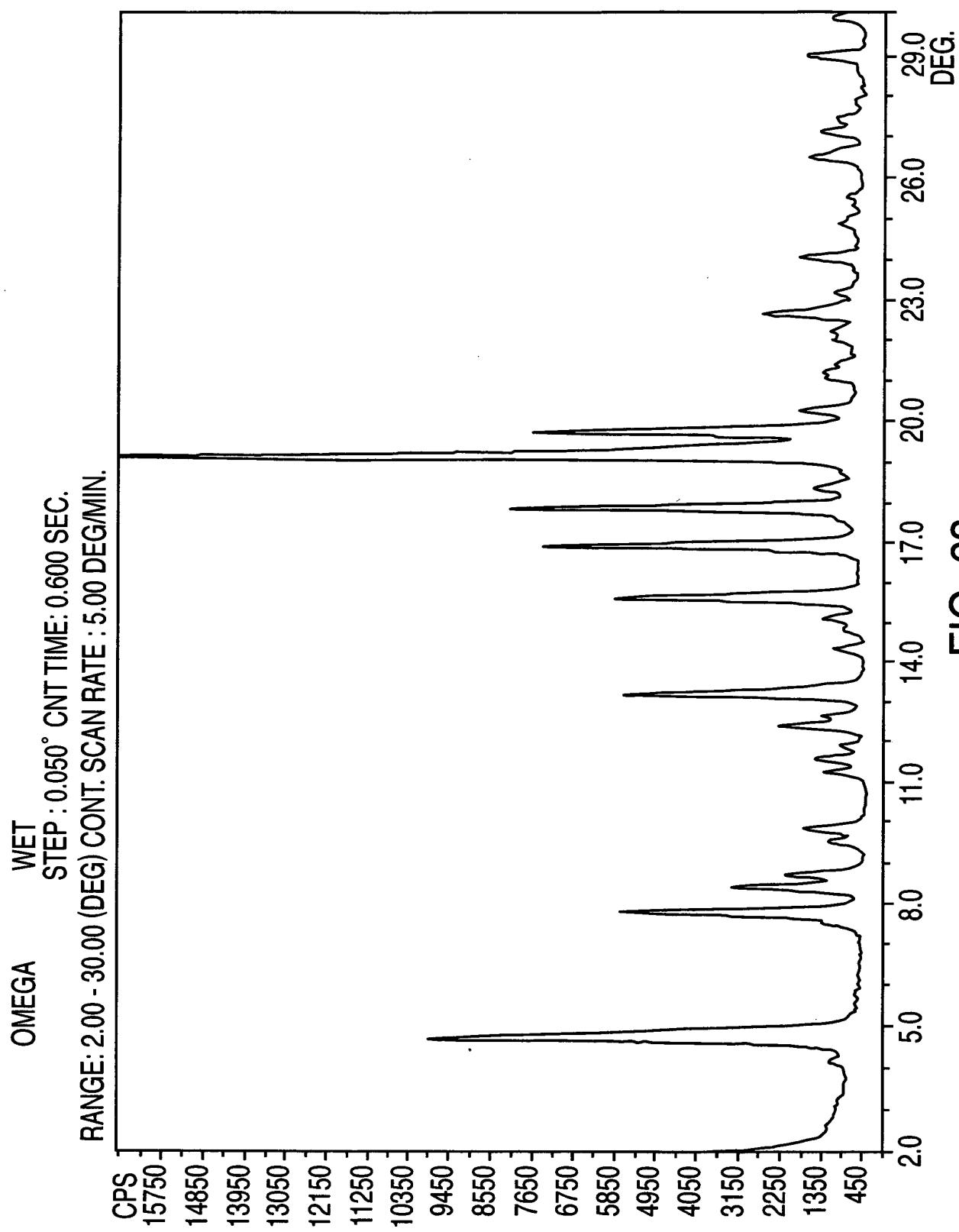


FIG. 63

Comparison between the impurity profile of Nateglinide crystallized in IPA-H₂O and Nateglinide in Methanol-H₂O

Sample No	Solvent	Impurity profile by RRT [% w/w]						
		D-PA (0.23)	(0.25) (0.46)	(0.80)	Ipcha (0.89)	Dimer (1.38)	Methyl Ester (1.51)	Isopropyl Ester (1.76)
RL-2155/1	Methanol-H ₂ O	<0.01	0.02	<0.01	0.03	0.02	2.91	0.04
RL-2163/4	IPA-H ₂ O	<0.01	0.04	0.02	0.02	0.01	0.03	0.02

Note: D-PA means D-Phenyl Alanine

Ipcha means Iso propyl cyclohexyl carboxylic acid

Both are the starting materials of the product

(-)N-[(trans-4-isopropyl cyclohexane)carbonyl]-D-phenylalanine

FIG. 64